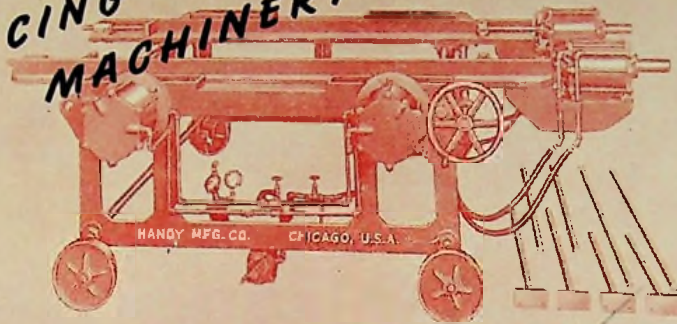


FEB 24 1950

PROFIT  
PRODUCING  
MACHINERY



**handy**

*absolute*

CATALOG No. 37

CLAMPING MACHINERY

PRESSES

ASSEMBLY MACHINERY

WOODWORKERS' CLAMPS

*HANDY* Manufacturing Company

2432 West Lawrence Avenue, Chicago 25, U. S. A.



# fine machinery

It is no accident that, with men who know, Handy equipment has a reputation for performing well, for staying on the job longer. Year after year, for more than forty years, the industry leaders have found that their men do better work faster with Handy machinery and they cannot make it wear out.

The reason for this is that Handy engineers always design machines which are simple to operate and rugged — without troublesome frills and gadgets. Handy machinery is well built, carefully built. It is distinguished by its extra heavy cast frames, rugged cast clamp-plates and other components, and accurate machining. Oversize pneumatic cylinders of special design are an important feature. These provide greater reserve power, smoother operation, and better control. Thus, maintaining Handy equipment in production is no problem at all.

Handy machinery is thoroughly practical and moderately priced; it is proven and dependable — worthy of your full confidence. Handy builds fine machinery.

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*this* **HANDY CATALOG** *no. 37*

*traditionally a practical reference book  
presents a wealth of ideas and equipment  
to enable your plant to produce more efficiently.*

*It contains data on by far the most complete and  
extensive line of assembly and clamping machinery.*

*Yet it cannot be complete—for Handy engineers  
each day are designing machines to do better  
the particular work of Handy customers old and new.*

*Only some of the equipment Handy builds  
is to be seen in this book.*

*The profit-production machines best for your needs  
may, in most instances, be readily selected  
from this catalog. But, at all times  
Handy will consider it a privilege  
to consult with you and  
after careful study of your specific requirements  
submit detailed recommendations of the  
correct equipment—standard or special—  
to do your job as it should be done.*

***HANDY** Manufacturing Company*

2432 WEST LAWRENCE AVENUE • CHICAGO 25 U. S. A.

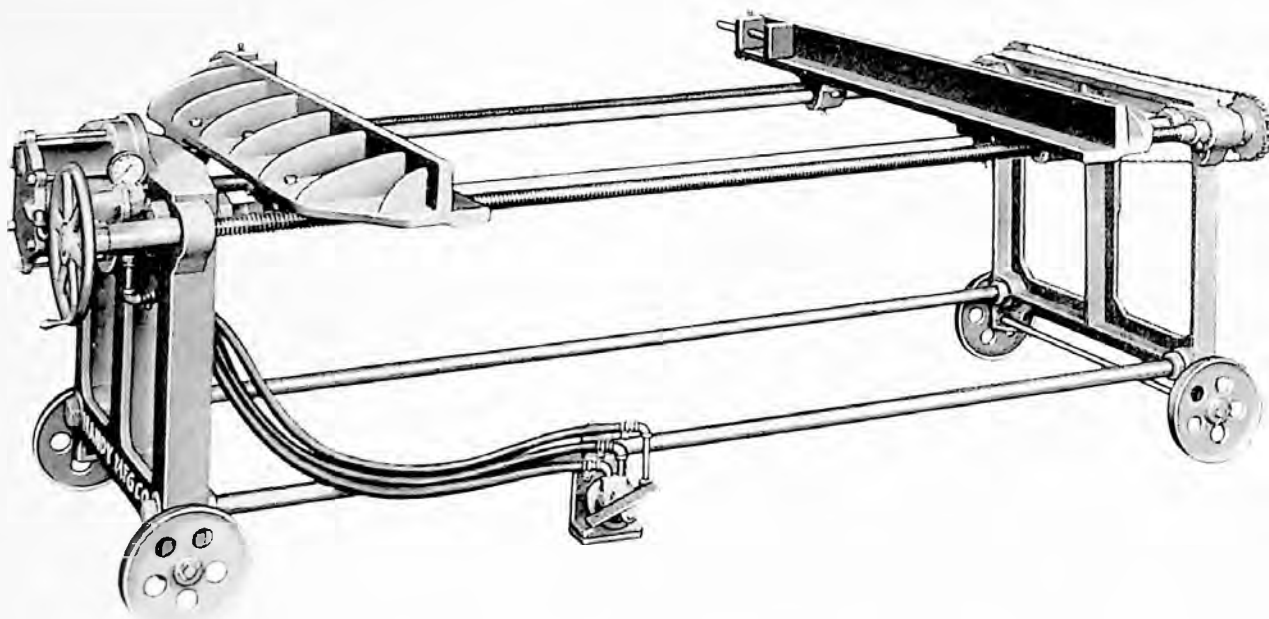
CABLE ADDRESS: HANDYCO





No. **415**  
SERIES

## CABINET AND CASE **End Clamps**



### *The Leaders for Decades—Now Finer Than Ever*

Handy End Clamps are almost universally used as basic equipment in assembling and squaring case ends, bed ends, panels, frames and sub-assemblies of many types. They are ruggedly and accurately built to perform superbly in their essential role in fine cabinet making.

The air-powered clamp-plate and the adjustable stationary clamp-plate, as well as the main structure of the clamp, are heavy castings, accurately machined. Operation is smooth and the life of these units is virtually unlimited. Each clamp is equipped with a conveniently located foot control, the pressure is set at any desired level by the pressure regulator and gauge and the speed of the clamping stroke is controlled by a speed valve.

Built in a wide range of sizes, one or more of these units are a must in most woodworking plants.

Handy End Clamps are built to stay in service; there are no gadgets or intricate mechanisms to cause trouble.

#### **FAST, EASY SETUP AND OPERATION**

The setup to various sizes is simple and fast. Normally, a glued-up master is placed in the clamp with the air-powered-clamp in the open position. The large handwheel is then turned to move the adjustable plate toward the work and it is locked by set screws at that distance from the master which will give the actual production clamping stroke desired.

The adjustable squaring stops on each jaw are then positioned accurately in line so that the work will be clamped, approximately in the center of the clamp jaws, squared and true.

This proven construction is best because there are no holes or pins to wear and cause inaccuracies.

*Additional data on next page*

*HANDY Manufacturing Company*  
CHICAGO 25 U.S.A.

# AIR-POWERED AND HAND-OPERATED



No. 415  
SERIES

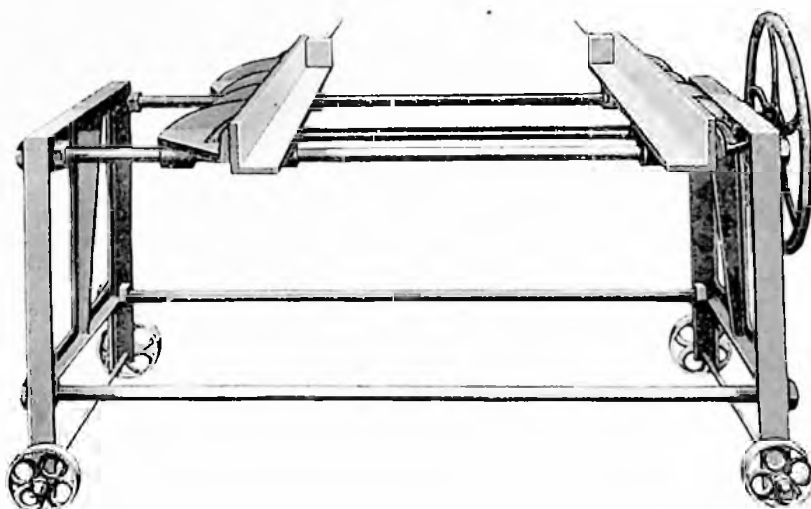
No. 9  
SERIES

## SPECIFICATIONS

### No. 415 Series Handy Air-Powered End Clamps

Standard Clamp Plates					Standard Cylinders			
No.	Length	Height	Max. Open.	Addl. Max. Open. Add	No.	Diam.	Stroke	Approx. Wt.
415	96"	3½"	48"	■	2	8"	2"	1875
416	90"	3½"	48"	■	2	8"	2"	1800
417	84"	3½"	48"	■	1	10"	2"	1750
418	71"	3½"	48"	■	1	10"	2"	1650
419	60"	3½"	48"	■	1	8"	2"	1350
420	55"	3½"	48"	■	1	8"	2"	1250
421	47"	3½"	48"	■	1	8"	2"	1200
422	36"	3½"	48"	■	1	8"	2"	1150

Machines with special dimensions can be supplied to meet any requirements.



## HAND-OPERATED End Clamps

The same sizes of End Clamps, hand screw operated, are available where the advantages of speed, uniform pressure and minimum dependency on operator fatigue—all obtainable with air power—are not required. In these units, a single heavy screw operates the clamp-plate for both setup and clamping. Squaring stops which are adjustable are mounted on each clamp-plate.

## SPECIFICATIONS

### No. 9 Series Handy Hand-Operated End Clamps

Standard Clamp Plates					
No.	Length	Height	Max. Open.	Addl. Max. Open. Add	Approx. Wt.
9	96"	3½"	48"	★	1600
10	90"	3½"	48"	★	1560
11	84"	3½"	48"	★	1525
12	71"	3½"	48"	★	1340
12½	60"	3½"	48"	★	1275
13	55"	3½"	48"	★	1140
14	47"	3½"	48"	★	1100
15	36"	3½"	48"	★	1050

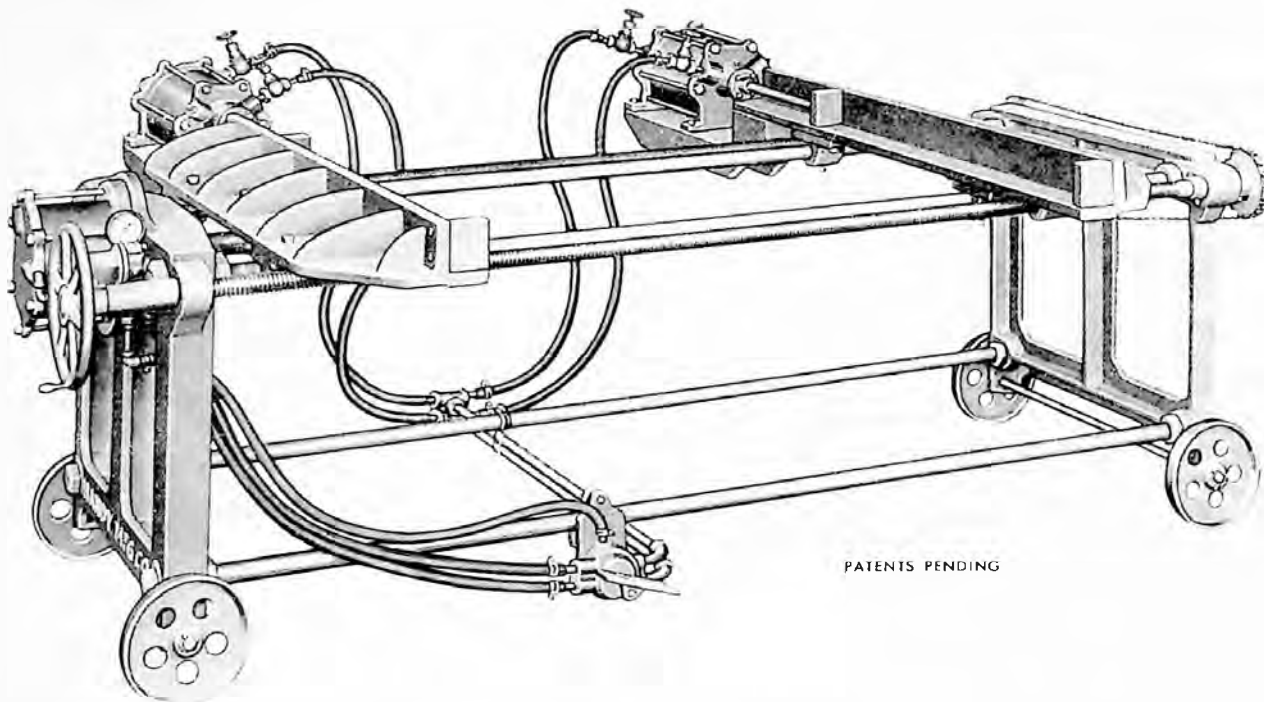
Machines with special dimensions can be supplied to meet any requirements.

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **460**  
SERIES

## DUAL-TRU End and Frame Clamps



PATENTS PENDING

### *Better Work—Faster and with Greater Precision*

The Handy Dual-Tru Clamps are designed along proven principles to speed assembly of a wide range of work. Frames of many types, case ends, table aprons and other assemblies which require not only major clamping pressure but also auxiliary aligning pressure at right angles are produced on these units. Spacing of the main clamp plates is quickly set by the large handwheel, and the speed and pressure of these plates are under the full control of the operator at all times. When desired, the main clamp plates alone may be used as with a standard end clamp. Adjustable squaring stops are provided. Double value is obtained by the ability to place the end pressure units in operation quickly, thus making the Dual-Tru Clamps a virtual necessity in the modern woodworking plant.

#### **EXCLUSIVE HOLLOW-BORE END-PRESSURE UNITS**

The Handy end-pressure units located at the end of each main clamp-plate are of exclusive hollow-bore construction. The pressure rods in each are quickly placed in any desired position and locked, the stationary cylinders exerting pressure perfectly on the work whether large or small. The moving of heavy cylinders is eliminated. The speed, pressure and timing of these end-pressure units are under complete control, and the exclusive in-line Center Pressure assures better clamping. If desired, forms may be attached to the blocks on the ends of the pressure rods. These rods are instantly aligned by accurately milled slots without the use of tools. When superb modern production machinery is wanted, Handy Dual-Tru is the answer.

*Additional data on next page*

*HANDY* Manufacturing Company  
CHICAGO 25 U. S. A.

# SUPER AIR-POWERED AND HAND-OPERATED



No. 460  
SERIES

No. 1  
SERIES

## SPECIFICATIONS

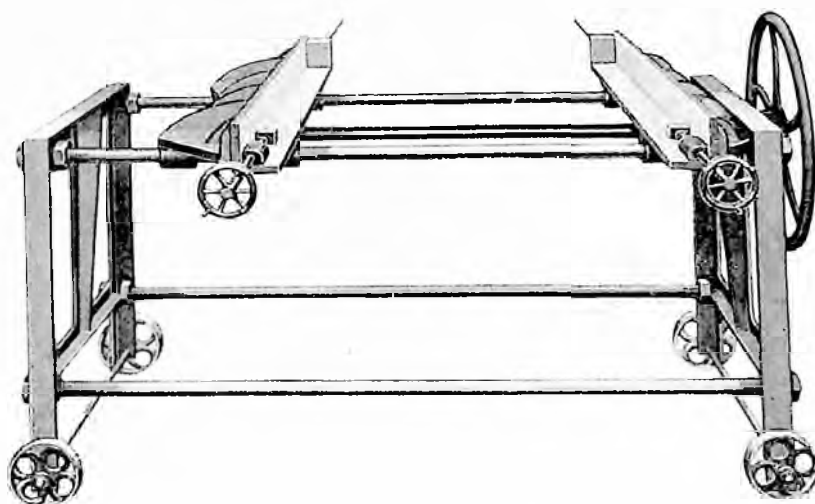
No. 460 Series Handy Dual-Tru End and Frame Clamp

Main Clamp Plates					Main Cylinders			End Pressure Cylinders			Approx. Wt.
No.	Length	Height	Max. Open.	Addl. Max. Open. Add	No.	Diam.	Stroke	No.	Diam.	Stroke	
460	35"	3 1/2"	48"	■	1	8"	2"	2	4 1/2"	5"	1900
461	46"	3 1/2"	48"	■	1	8"	2"	2	4 1/2"	5"	1950
462	54"	3 1/2"	48"	■	1	8"	2"	2	4 1/2"	5"	2000
463	59"	3 1/2"	48"	■	1	8"	2"	2	4 1/2"	5"	2100
464	70"	3 1/2"	48"	■	1	10"	2"	2	6 1/2"	5"	2500
465	83"	3 1/2"	48"	■	1	10"	2"	2	6 1/2"	5"	2600
466	88"	3 1/2"	48"	■	2	8"	2"	2	6 1/2"	5"	2700
467	95"	3 1/2"	48"	■	2	8"	2"	2	6 1/2"	5"	2800

Machines with special dimensions can be supplied to meet any requirements.

## HAND-OPERATED End and Frame Clamps

In instances where the advantages of air power are not wanted, the Handy Hand-Operated End and Frame Clamps are available. One main clamp-plate is fixed and the other is operated for adjustment and clamping by a quick-acting screw controlled by a large hand-wheel located on one end of the clamp. Each main clamp-plate is equipped with an adjustable squaring stop on the far end, and, on the near end, there is a screw fixture operated by a handwheel for applying end pressure. This screw fixture can be mounted in either of two positions.



## SPECIFICATIONS

No. 1 Series Handy Hand-Operated End and Frame Clamp

Main Clamp Plates in the Clear					End Screw Fixtures Travel	Approx. Wt.
No.	Length	Height	Max. Open.	Addl. Max. Open. Add		
1	31"	3 1/2"	48"	★	11 1/2"	1375
2	42"	3 1/2"	48"	★	11 1/2"	1425
3	50"	3 1/2"	48"	★	11 1/2"	1475
4	55"	3 1/2"	48"	★	11 1/2"	1575
5	66"	3 1/2"	48"	★	11 1/2"	1715
6	79"	3 1/2"	48"	★	11 1/2"	1955
7	84"	3 1/2"	48"	★	11 1/2"	1985
8	91"	3 1/2"	48"	★	11 1/2"	2025

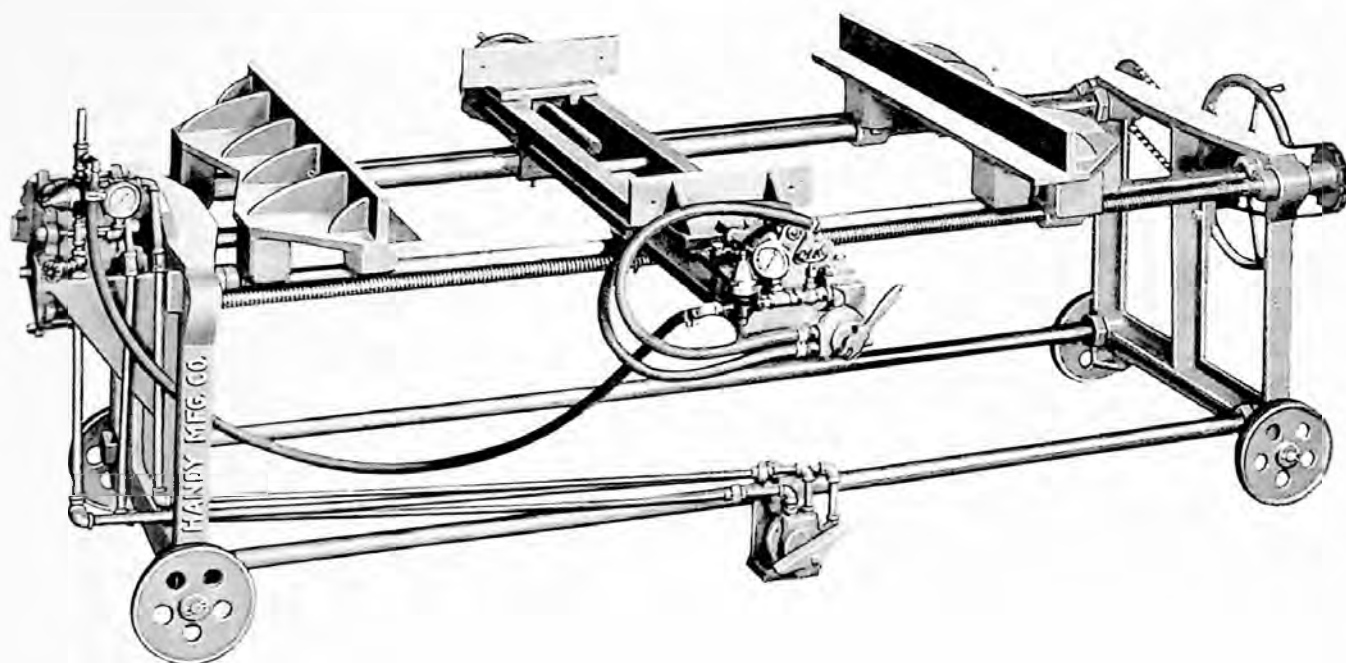
Machines with special dimensions can be supplied to meet any requirements.

*HANDY* Manufacturing Company  
CHICAGO 25 U. S. A.



No. **440**  
SERIES

## TWO-WAY End Clamps



### *Perfectly Controlled Pressure in Each Direction*

These versatile units, available in a wide range of capacities, are considered basic equipment wherever two-way or two-directional clamping is required for assembly, squaring and clamping. The pressure, in either direction, is individually controllable by the operator so that pressure may be applied in both directions simultaneously or in sequence. Likewise, pressure and speed of both the main clamp plate and the crossway plate may be independently set at any desired amount.

Fast adjusting wheels are provided for set-up of main plates and crossway plates and this makes possible exact set-up in the minimum amount of time without the use of troublesome stops.

The crossway clamp plates may be quickly located by sliding to any desired position between the main

clamp plates. The entire crossway assembly can be easily removed at any time this may be desirable. The crossway plates have holes for attaching wood forms or fill-in blocks so that pressure may be exerted along the entire side of the work being clamped or along irregular contours.

#### **SIZES OF CROSSWAY PLATES**

The length of the short crossway plates should normally be specified so that it is shorter than the narrowest work to be run. Fill-in blocks then will be attached when wider work is being clamped. Lengths of crossway plates available for both the No. 440 Series and the No. 18 Series are: 13", 14", 15", 17", 18", 20", 23½", 29½", and 35½".

*Additional data on next page*



# AIR-POWERED AND HAND-OPERATED



No. 440  
SERIES

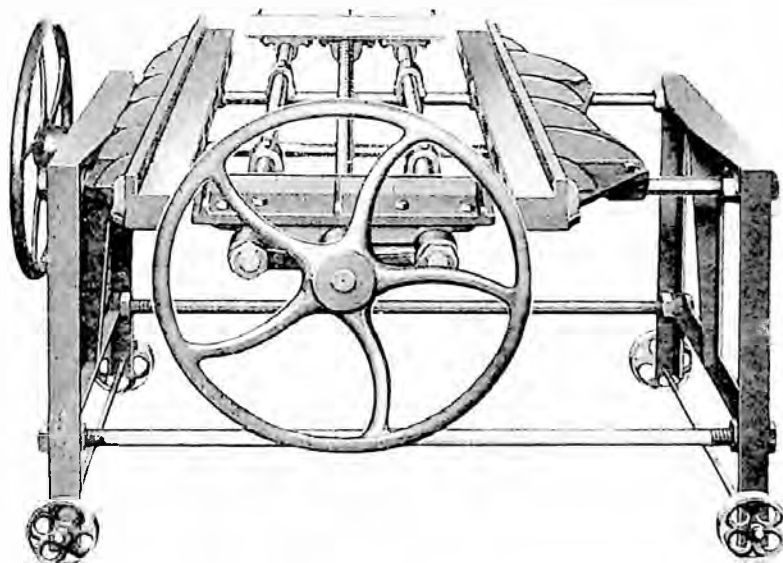
No. 18  
SERIES

## SPECIFICATIONS

### No. 440 Series Handy Air-Powered Two-Way End Clamps

Main Clamp Plates					Crossway Plates			Main Cylinders			Crossway Cyl.		Approx. Wt. Lb.
No.	Lgth.	Hgt.	Max. Open.	Addl. Open. Add	Lgth.	Hgt.	Max. Open.	No.	Diam.	Stroke	Diam.	Stroke	
440	97"	3½"	48"	★	23½"	3½"	99"	2	8"	2"	4½"	2"	3200
441	91"	3½"	48"	★	23½"	3½"	93"	2	8"	2"	4½"	2"	3125
442	85"	3½"	48"	★	20"	3½"	87"	1	10"	2"	4½"	2"	2850
443	72"	3½"	48"	★	20"	3½"	74"	1	10"	2"	4½"	2"	2200
444	61"	3½"	48"	★	15"	3½"	63"	1	8"	2"	4½"	2"	2000
445	56"	3½"	48"	★	15"	3½"	58"	1	8"	2"	4½"	2"	1850
446	48"	3½"	48"	★	15"	3½"	50"	1	8"	2"	4½"	2"	1750
447	37"	3½"	48"	★	15"	3½"	39"	1	8"	2"	4½"	2"	1626

Machines with special dimensions can be supplied to meet any requirements.



## HAND-OPERATED TWO-WAY END CLAMPS

Where the advantages of air power are not wanted, these hand-operated units are available for two-way clamping. Absolute accuracy is assured and the crossway unit may be quickly adjusted to center on the work in both directions. The crossway attachment has a left hand thread so that the operator may easily turn both screws at one time.

## SPECIFICATIONS

### No. 18 Series Handy Hand-Operated Two-Way End Clamps

Main Clamp Plates					Crossway Plates			Approx. Wt. Lbs.
No.	Lgth.	Hgt.	Max. Open.	Addl. Open. Add	Lgth.	Hgt.	Max. Open.	
18	97"	3½"	48"	★	23½"	3½"	99"	2100
19	91"	3½"	48"	★	23½"	3½"	93"	2045
20	85"	3½"	48"	★	20"	3½"	87"	1975
21	72"	3½"	48"	★	20"	3½"	74"	1780
21 ½	61"	3½"	48"	★	15"	3½"	63"	1625
22	56"	3½"	48"	★	15"	3½"	58"	1540
23	48"	3½"	48"	★	15"	3½"	50"	1390
24	37"	3½"	48"	★	15"	3½"	39"	1325

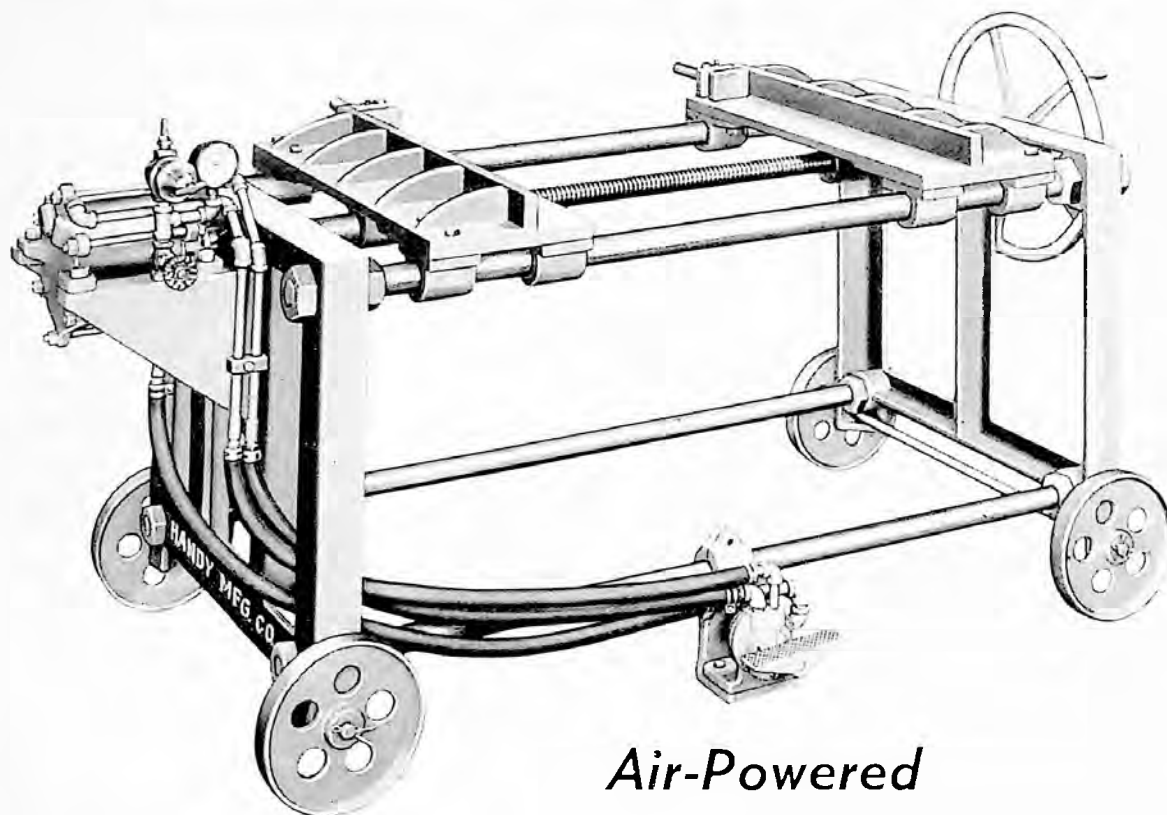
Machines with special dimensions can be supplied to meet any requirements.

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. 30  
SERIES

## SMALL SIZE End Clamps



### *Production Ease for Small Assemblies Such as Chair Seats*

Where quantities to be run are small, the hand-operated screw-type clamp is available. No. 30 has been extensively used for many years by plants all over the world. The handwheel moves clamping plate toward operator in this manual model.

#### SPECIFICATIONS

No. 30 Handy Hand-Operated End Clamp				
Standard Clamp Plates			Addl.	
		Max.	Open.	Approx.
Length	Height	Open.	Add	Wt.
27"	2"	32"	*	540

*Machines with special dimensions can be supplied to meet any requirements.*

### *Air-Powered*

For small work, such as table radio cabinet frames and chair seats, these smaller size end clamps are well adapted. Even though small in size, these units give the dependability and ruggedness obtainable only with heavy cast end-frames and accurately machined cast clamping jaws. Adjustment for size is quickly made by the handwheel, and adjustable squaring stops are provided on each clamp-plate to assure absolute squareness. Because of the accurately controlled air power, operation is fast and results uniform. Equipped with pressure regulator and gauge, speed valve and foot control valve.

#### SPECIFICATIONS

No. 31 Handy Air-Powered End Clamp						
Standard Clamp Plates			Addl.	— Standard Cylinder —		
		Max.	Open.			Approx.
Length	Height	Open.	Add	No.	Diam.	Stroke
27"	2"	32"	*	1	6½"	2"
						Wt.
						650

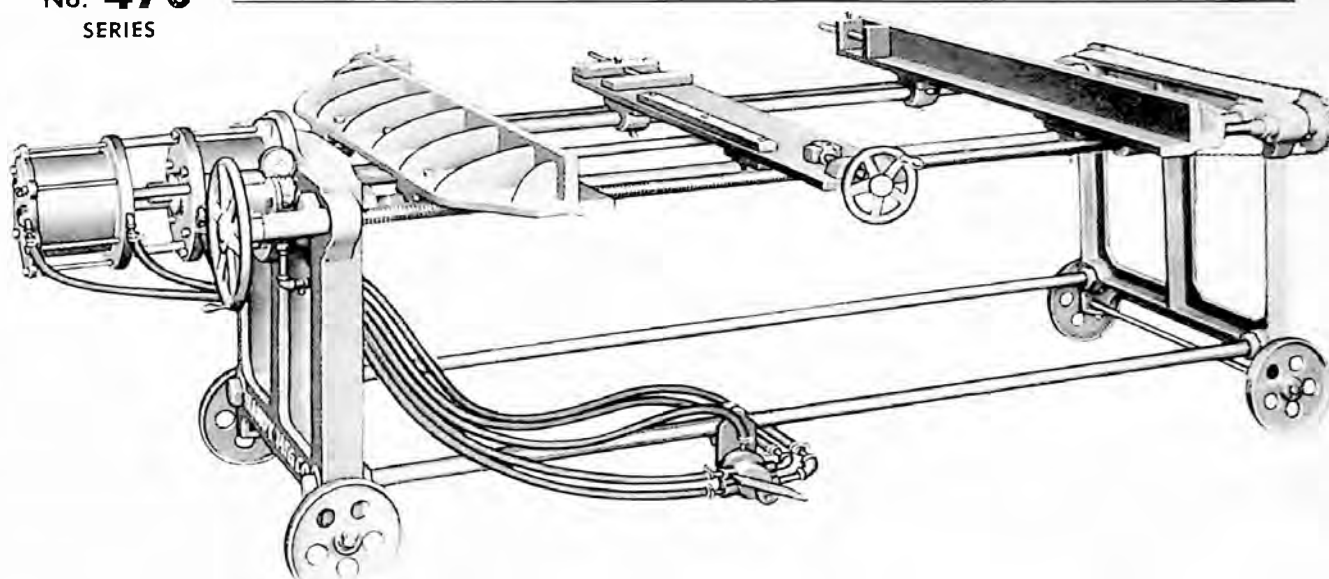
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **470**  
SERIES

# TRI-JAW Wardrobe Frame Clamps



## New Efficiency for a Difficult Clamp Job

These ingenious clamping machines are the only entirely satisfactory method of producing many types of cabinet and case goods frames, such as for chifforobes or wardrobes, designed with short parting rails ending in a central post. The pressure, under the operator's complete control at all times, is applied independently to the main frame and then to the central post to draw up the rails so that every joint is tight. Perfectly square and true work is run at far greater speed than ever before possible.

The handwheel quickly positions the fixed main clamp-plate for the frame size and the central jaw, equipped with an auxiliary screw plate, is also correctly positioned with ease. The straight line pressure is applied to the two separately moving jaws through the exclusive use of one hollowbore cylinder through which the piston rod of the second cylinder operates. There are adjustable squaring stops on all three clamp-plates.

### SPECIFICATIONS

#### No. 470 Series Handy Air-Powered Tri-Jaw Wardrobe Frame Clamps

—Clamp Plates—				Addl.	Main Cylinders			Approx. Wt.
No.	Length	Height	Max. Open.	Open. Add	No.	Diam.	Stroke	
470	36"	3½"	48"	■	2	8"	2"	1800
471	47"	3½"	48"	■	2	8"	2"	1860
472	55"	3½"	48"	■	2	8"	2"	1920
473	60"	3½"	48"	■	2	8"	2"	2040
474	71"	3½"	48"	■	2	10"	2"	2510
475	84"	3½"	48"	■	2	10"	2"	2640

Machines with special dimensions can be supplied to meet any requirements.

*The screw type Tri-Jaw frame clamps employ two hand-operated screws, one within the other, operated by two wheels at one end of the clamp.*

### SPECIFICATIONS

#### No. 101 Series Handy Hand-Operated Tri-Jaw Wardrobe Frame Clamps

Clamp Plates					
No.	Length	Height	Max. Open.	Addl. Open, Add	Approx. Wt.
101	36"	3½"	48"	■	1620
102	47"	3½"	48"	■	1680
103	55"	3½"	48"	■	1730
104	60"	3½"	48"	■	1800
105	71"	3½"	48"	■	2030
106	84"	3½"	48"	■	2250

Machines with special dimensions can be supplied to meet any requirements.

*HANDY* Manufacturing Company

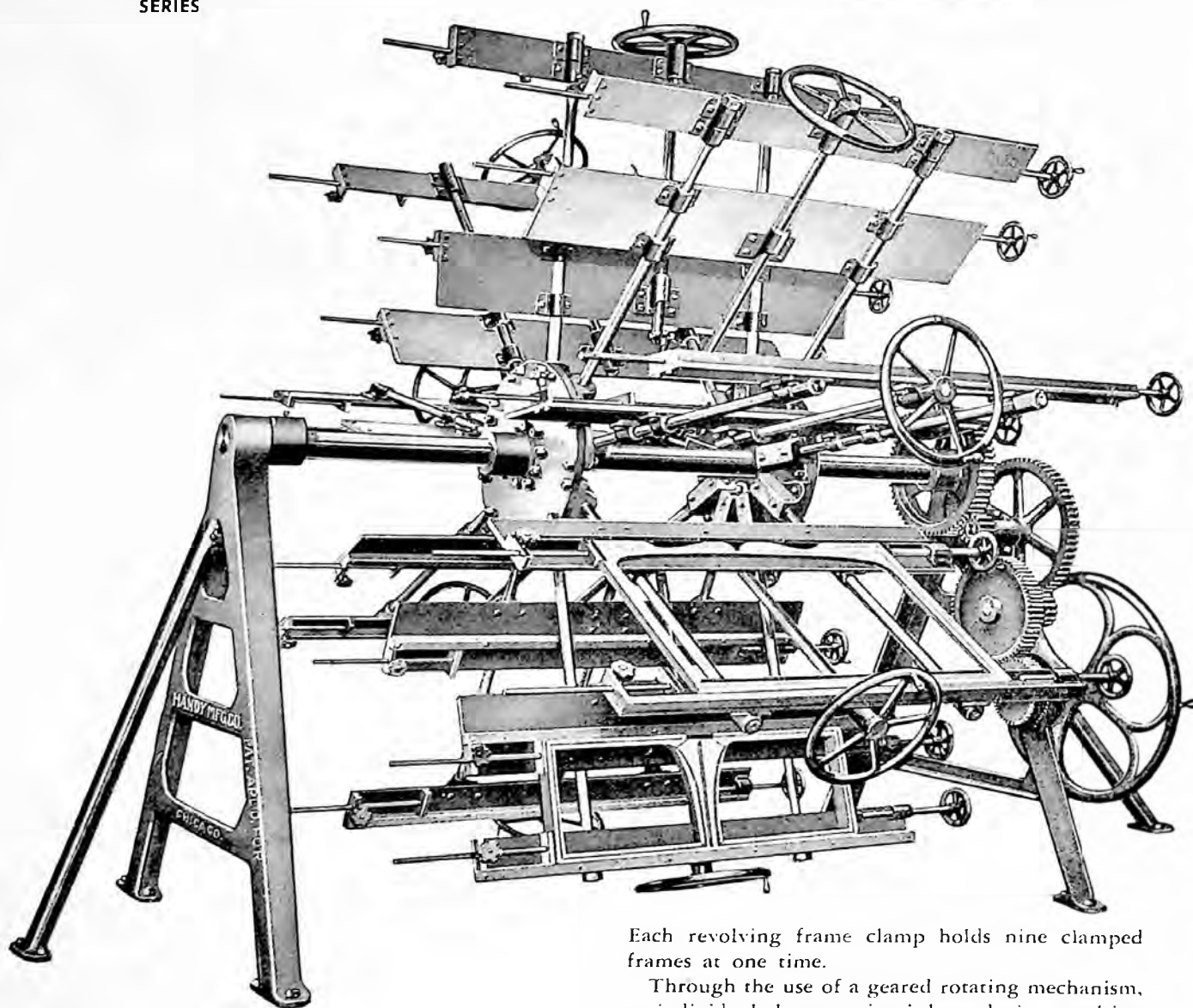
CHICAGO 25 U.S.A.





No. **128**  
SERIES

## REVOLVING **Frame** Clamps



### *For Production Clamping*

Revolving Frame Clamps provide the means, within a limited floor space, of producing quantities of glued-up frames and make it possible to allow the frames to remain clamped until the glue sets.

Each revolving frame clamp holds nine clamped frames at one time.

Through the use of a geared rotating mechanism, an individual clamp section is brought into position for removal of a frame clamped earlier and then the placing of a new frame to be drawn up and squared. Due to the back gearing, the operator can bring any clamp section to the desired position and there is no need of locks.

*Additional data on next page*

*HANDY Manufacturing Company*  
CHICAGO 25 U.S.A.

## WITH NINE TWO-WAY SECTIONS

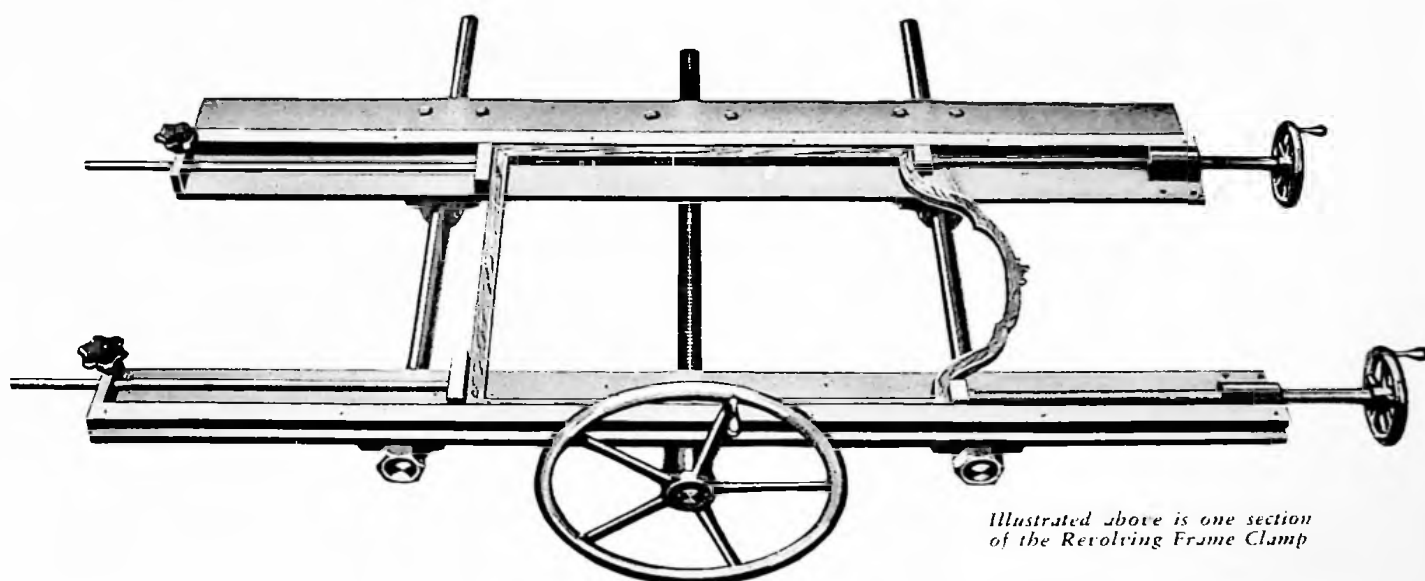


No. **128**  
SERIES

### *Ideal for Continuous Clamping of Cabinet Frames*

Each individual section, as illustrated below, is ruggedly constructed so as to perfectly clamp radio cabinet frames, picture frames or other frame work of any kind. Standard jaws are 1 1/4" high and close to 8". The jaws and jaw plates are made of cold drawn steel and provides a 4" table area. Pressure is applied by a fast traveling screw.

Crossway pressure, when required, is provided by two screws with wheels. These crossway pressure screws can be located close to the jaw, as shown, or moved to the outer edge of the plate. When small frames are being run, more than one at a time can be placed in a section. Adjustable squaring stops are located at left end of plates.



*Illustrated above is one section  
of the Revolving Frame Clamp*

The Revolving Frame Clamp with frames 60" long requires 12 ft. floor space in length. A machine with clamp sections with a capacity for 32" wide frames is 9' 6" high. A machine with clamp sections with a capacity for 36" wide frames is 10' 6" high.

A motor drive for revolving the entire unit can be supplied at additional cost.

#### SPECIFICATIONS

##### No. 128 Series Handy Revolving Frame Clamps

No.	Maximum Capacity of Each Section		Approx. Wt.
	Length	Width	
128	60"	36"	6600
129	54"	36"	6500
130	48"	36"	6400
131	42"	36"	6300
132	36"	36"	6200
133	30"	36"	6100
134	60"	32"	6500
135	54"	32"	6400
136	48"	32"	6300
137	42"	32"	6200
138	36"	32"	6100
139	30"	32"	6000

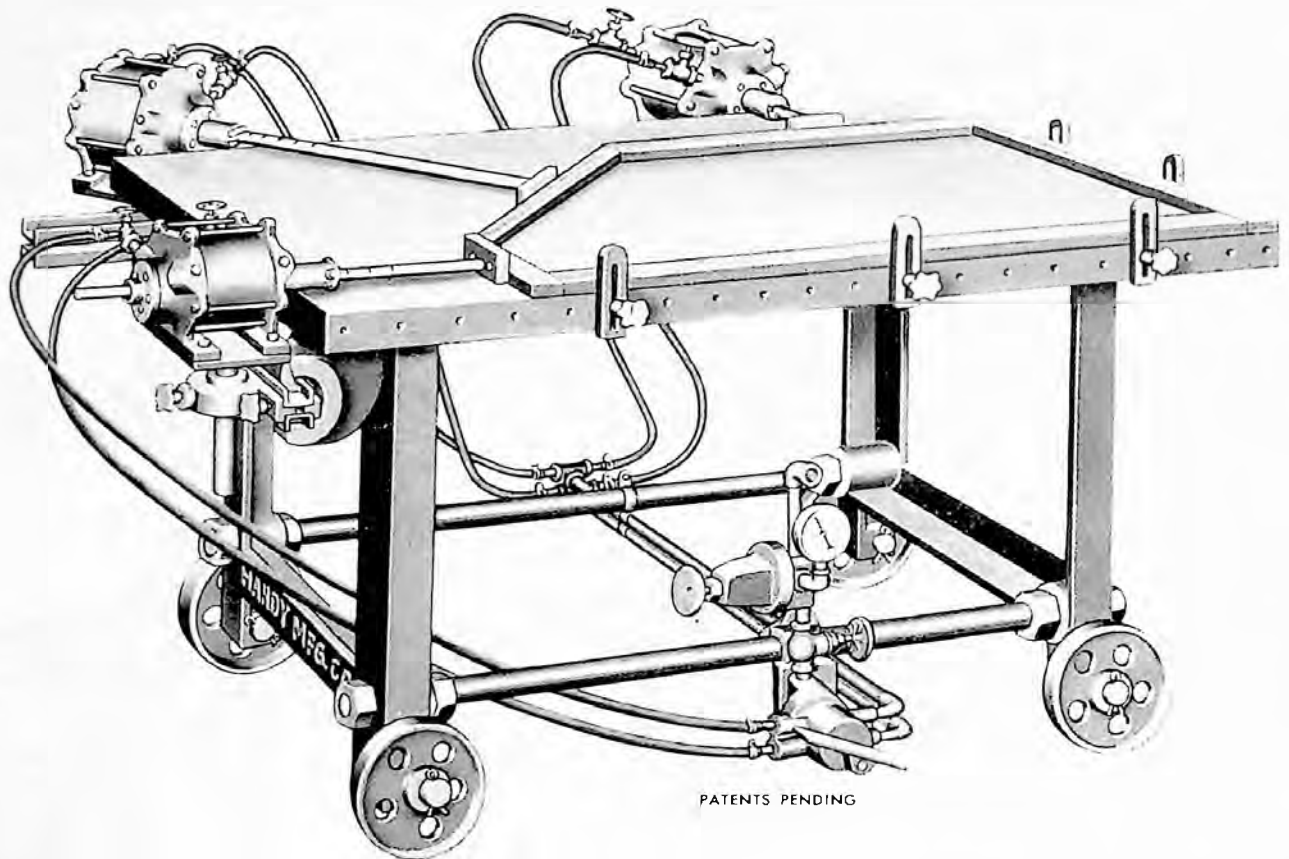
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **165**  
SERIES

## ADJUSTO-SPEED Clamping Machine



PATENTS PENDING

### *Powerful and Versatile for Fastest Production*

Such versatility, power and speed have never before been built into one fine clamping unit. No. 165 Handy Adjusto-Speed is the outstanding answer to the need for an extremely flexible assembly unit incorporating an accurately machined work-table. It combines such flexibility of controlled pressure and such convenience of design that it steps up production doing scores of varied jobs.

Among the multitude of uses are the clamping up of frames, irregular in shape as well as rectangular; edge banding of tops for tables, desks and other case goods; and as a universal fixture for assembly and for radio frequency curing of glue joints.

The Handy Adjusto-Speed is equipped with exclusive hollow-bore pressure-units. These units are of ingenious construction permitting pressure to be applied at any desire point on the work and exerting pressure at the correct angle for the job. To attain the best results, pressure-units can be controlled to operate in the desired sequence and each may be set for any speed or may be completely cut off as needed.

Additional pressure-units may be added as original equipment or at a later time.

*Additional data on next page*

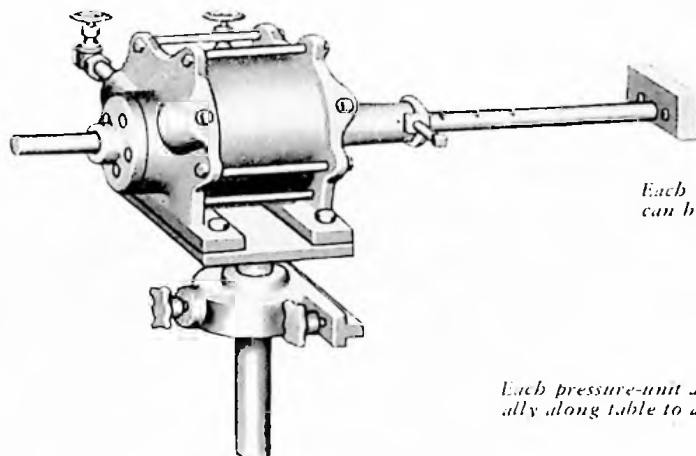
*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



# FLEXIBLE AIR-POWERED PRESSURE UNITS



No. **165**  
SERIES



*Each push-rod is instantly adjustable to reach and apply pressure on the work.*

*Each powerful pressure-unit can be set at any desired angle.*

*Each pressure-unit is adjustable for height above the table.*

*Each pressure-unit adjusts laterally along table to any position.*

## Clamps All Frames — No Matter What the Shape

The ability to clamp any frame or assembly, even of irregular shape, is accomplished by the universal adjustment of the pressure-units. Each pressure-unit can instantly be placed and locked in the proper position along the work-table by sliding it in the trackways located along the two sides of the machine. It is then swivelled to the correct angle and locked at the desired height above the work-table. Then, the pressure rods, which pass through the hollow-bore cylinders, are positioned to any desired length to contact the work and are locked. Handy No. 165 is quickly set up without tools for each new job. The unit produces perfect assemblies and has

the power and ruggedness, the flexibility of control, and the accuracy which is essential.

### ACCURATE WORK-TABLE

The heavy cast work-table is accurately machined to permit precision work. The assembly to be clamped is always located in the corner nearest the operator. At the operator's station is the pressure regulator and gauge, the master speed valve and the foot control valve which permits all pressure units to move at once or in sequence—first one group, then the other.

### SPECIFICATIONS

No. 165 Series Handy Adjusto-Speed Clamping Machine

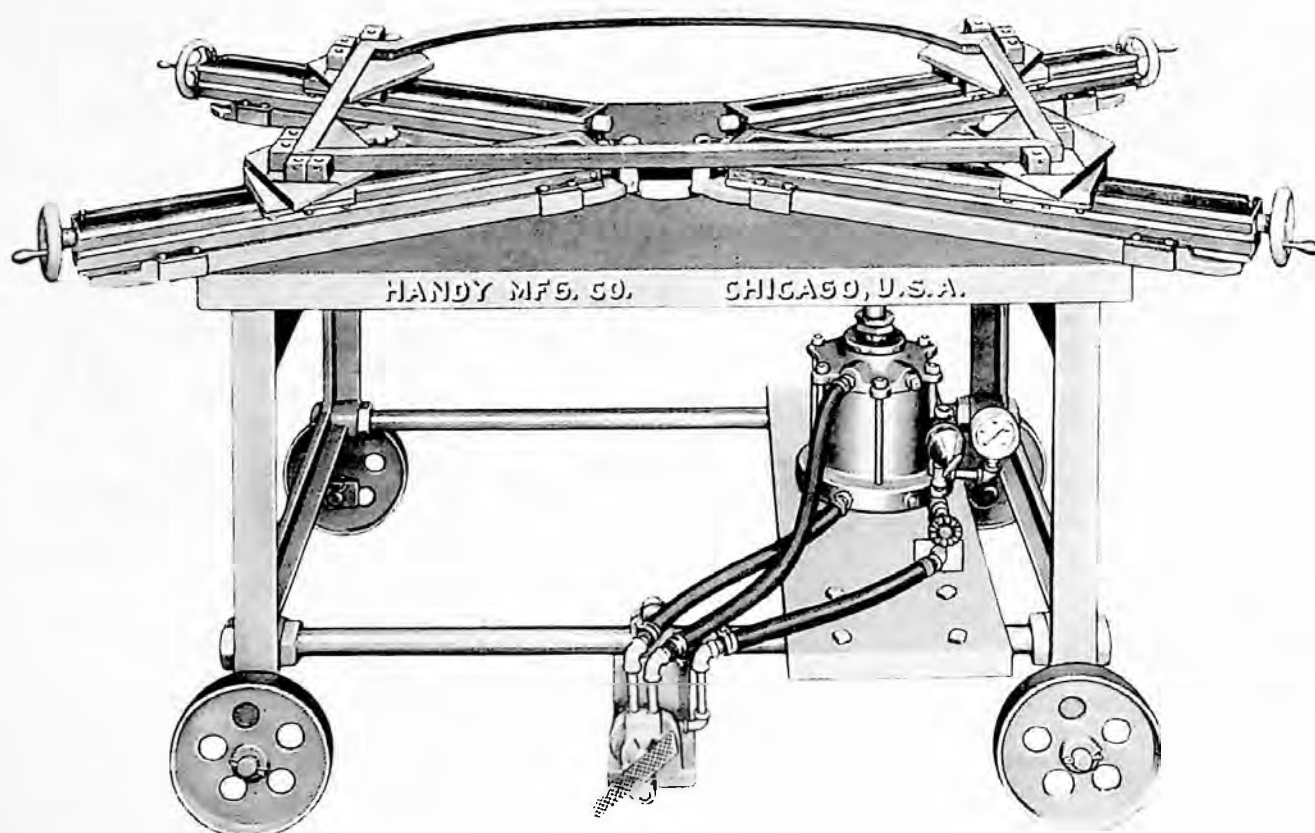
No.	Maximum Capacity in the Clear	Standard Minimum Capacity	Pressure-Units			Pressure Units Vertical Adjustment	Approx. Wt.
			No.	Diam.	Stroke		
165	52" x 38"	28" x 14"	3	4 1/2"	5"	4"	2200
166	66" x 48"	42" x 24"	3	4 1/2"	5"	4"	2275
167	86" x 48"	62" x 24"	3	4 1/2"	5"	4"	2375
168	98" x 38"	74" x 14"	3	4 1/2"	5"	4"	2225

*Note: If a smaller minimum capacity is required, additional longer pressure rods can be supplied at extra cost. Machines with special dimensions can be supplied to meet any requirements.*

No. 165B Pressure-Unit only for Adjusto-Speed Clamping Machines.

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.

## QUICK-ACTING MITRE **Frame** Clamp



### *Frames and Table Tops Produced Perfectly*

For mitre joint work, the Handy Quick-Acting Mitre Frame Clamp is unequalled. No other completely satisfactory method of drawing up mitre joints has ever been devised. This is due to the ideal basic principle of these units.

The superb results are obtained because pressure is applied to each of the four corners, along the line of the joint, towards the center. This four-way pressure, applied at each corner, draws up each joint perfectly and assures absolute squareness of the as-

sembly. Perfect mitre joints produced with the speed of this quick-acting clamp eliminate the costs of excessive sanding and assure a better product.

Adjustments to a wide range of sizes are made quickly and the work is within easy reach of the operator or operators for driving screws, nails or clamp nails where these are to be used.

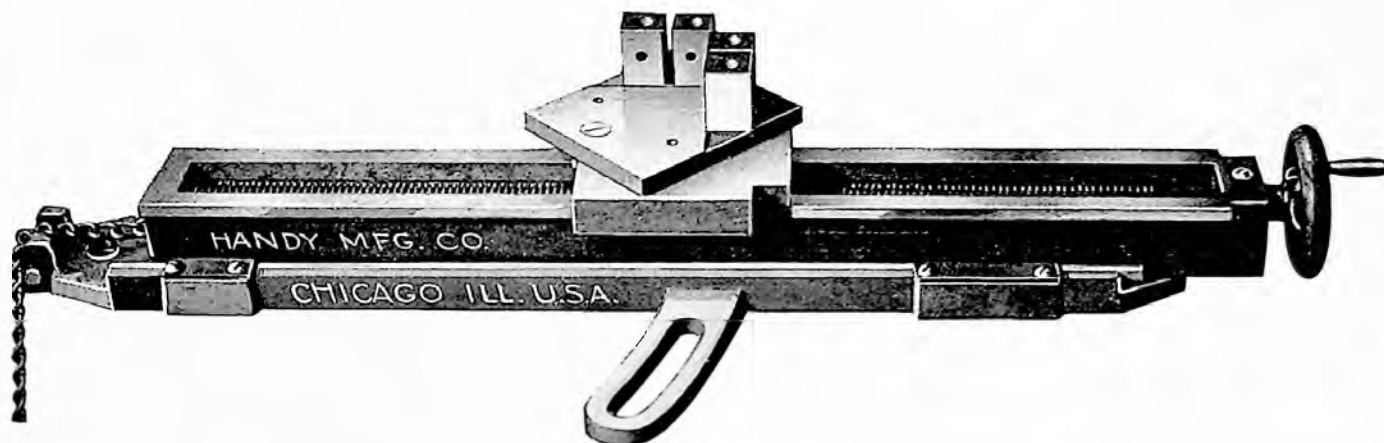
This unit, without question, is the finest available for producing mitre frames and other similar work.

*HANDY Manufacturing Company*
  
 CHICAGO 25 U. S. A.

# AIR - POWERED and FOOT-OPERATED



No. 160  
SERIES



## Draws Up Mitre Joints Tight and True Every Time

Shown above is one of the four individual clamping units. These are adjusted to apply pressure along the line of the joint and the small handwheel is used only to set up for size. Each of these clamping units is equipped with a swivel plate into which are mounted four blocks forming the right angle corner. Any of these blocks may be removed so that screws or nails may be inserted in the work. Holes are provided to attach wooden forms to conform to work with irregular contours.

### SPECIFICATIONS

#### No. 161 Handy Air-Powered Quick-Acting Mitre Frame Clamp

Standard Clamp Blocks	Standard Cylinder
Height.....1 1/8" each	Number.....1
Width.....1 1/8" each	Diameter.....6 1/2"
Width of two....2 3/4"	Approx. Wt....1400
Capacity—any combination of sizes between 13" x 10", 16" x 9" and 54" x 40", 50" x 44", 60" x 30"	

Machines with special jaws can be supplied to meet any requirements.

## Wide Range of Sizes Easy, Fast Set-Up

In setting up, a glued-up master frame is placed approximately in the center of the clamp. The foot control is operated to close the clamp only the amount of stroke desired in production. Each clamping unit is then properly positioned and the handwheels turned to bring the jaws to the work. Set-screws are then tightened to hold this setup and maintain absolute uniformity.

### SPECIFICATIONS

#### No. 160 Handy Foot-Operated Quick-Acting Mitre Frame Clamp

In this unit, clamping pressure is applied by operation of a large foot pedal. Upon completion of the clamp stroke, the pedal may be locked to hold pressure until the operator wishes to release it.

Standard Clamp Blocks	
Height.....	1 1/8" each
Width.....	1 1/8" each
Width of two.....	2 3/4"
Capacity—any combination of sizes between 13" x 10", 16" x 9" and 54" x 40", 50" x 44", 60" x 30"	
Approx. wt.....	1300

Machines with special jaws can be supplied to meet any requirements.

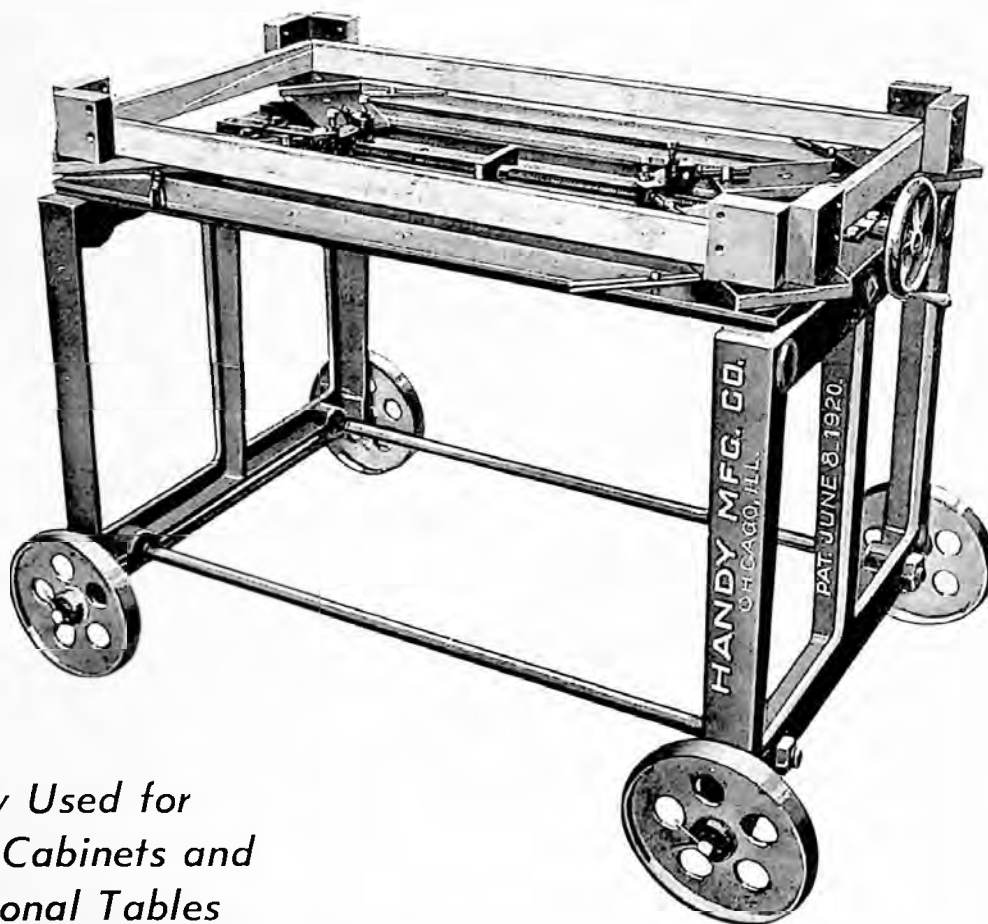
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No. **195**  
SERIES

## MITRE-JOINT Frame Clamp



### *Widely Used for Radio Cabinets and Occasional Tables*

For efficient drawing up of mitre-joint frames, this hand-operated unit has proved its value in many cabinet plants. It is easily set up to apply pressure at each joint at the proper angle. Each sliding jaw plate swivel has an individual adjustment. Holes are provided in the jaws for attaching forms should they be required. In operation, a hand wheel is turned and the right and left hand screw moves the jaws towards the center to make tight, perfectly aligned joints. Handwheels are supplied for both ends of the clamp.

The standard jaws, as shown, are  $3\frac{5}{16}$ " high and  $3\frac{1}{8}$ " wide. Other types of jaws can be supplied.

#### SPECIFICATIONS

##### No. 195 Mitre-Joint Frame Clamp

Maximum Capacity: 24" x 49"

Minimum Capacity: 14" x 16"

Jaws: Height— $3\frac{5}{16}$ "

Width— $3\frac{1}{8}$ "

Approx. Wt.: 650 lbs.

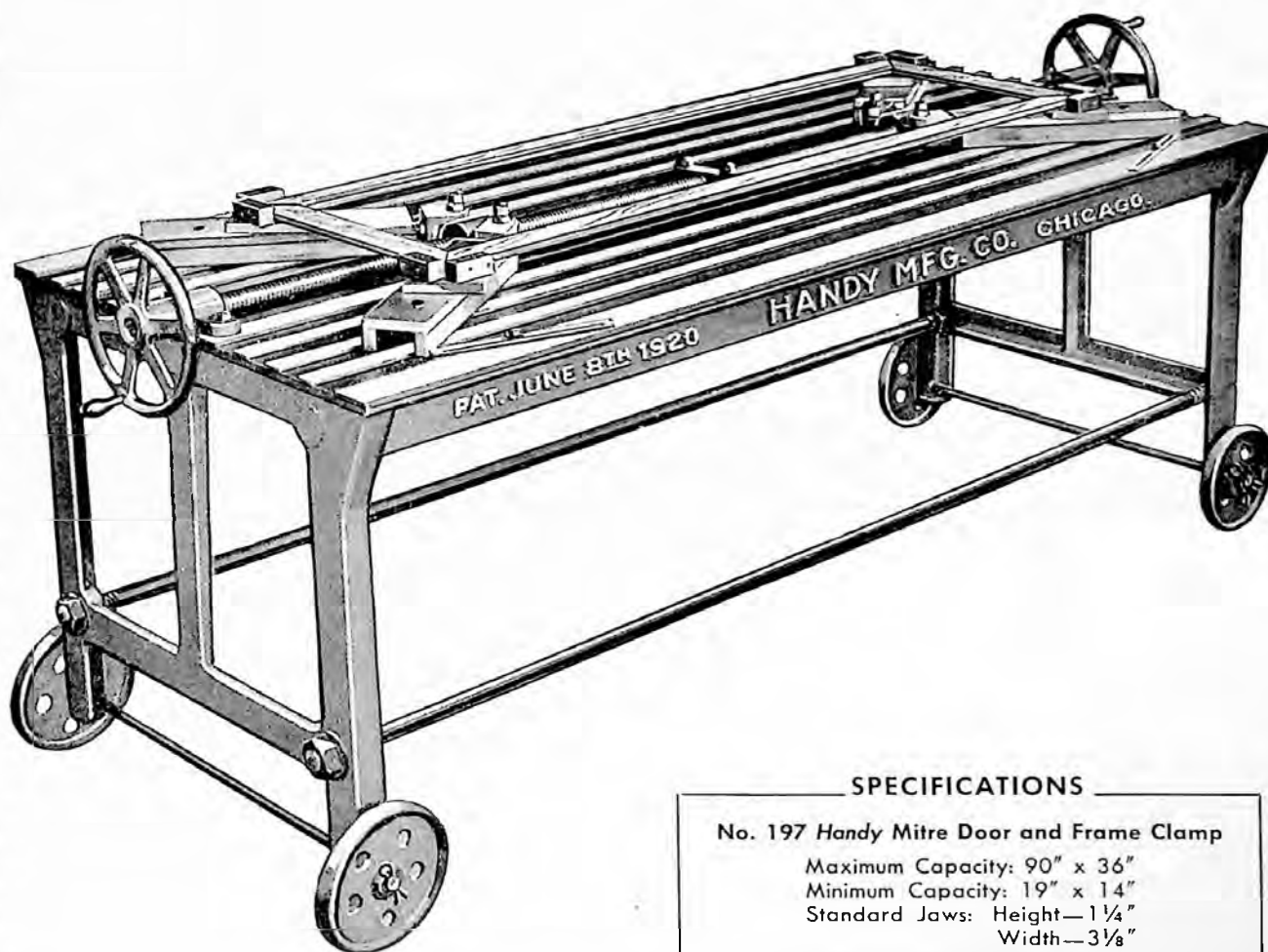
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY* Manufacturing Company  
CHICAGO 25 U. S. A.



No. 197  
SERIES

# MITRE Door and Frame Clamps



## For Larger Sizes of Mitre-Joint Work

For long mitre frames and interior trim with mitre joints, this unit provides faster production. Because it applies pressure precisely at each corner, good joints are assured. Setup is accomplished easily and the wheels at each end of the unit, operating the right and left hand screw, are within easy reach of the operator at all times.

### SPECIFICATIONS

#### No. 197 Handy Mitre Door and Frame Clamp

Maximum Capacity: 90" x 36"

Minimum Capacity: 19" x 14"

Standard Jaws: Height—1 1/4"  
Width—3 1/8"

Approx. Wt.: 1350 lbs.

#### No. 198 Handy Mitre Door and Frame Clamp

Maximum Capacity: 74" x 28"

Minimum Capacity: 19" x 14"

Standard Jaws: Height—1 1/4"  
Width—3 1/8"

Approx. Wt.: 1250 lbs.

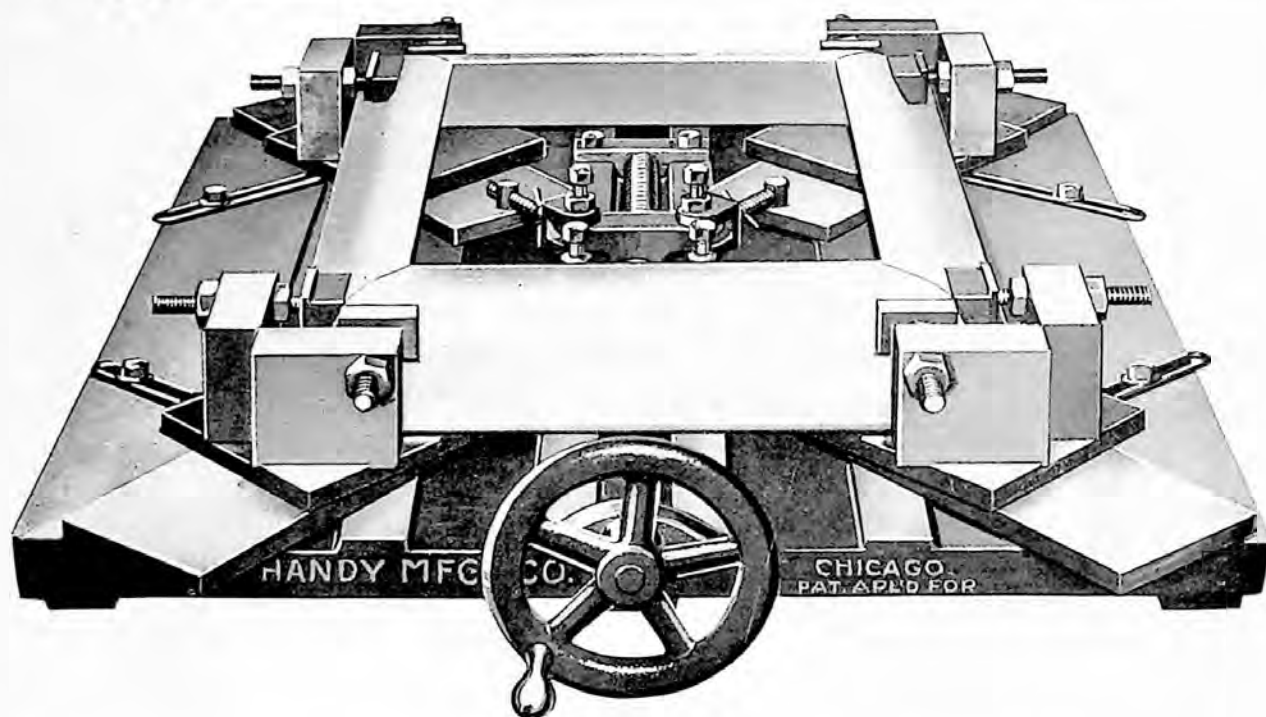
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. 190

## MITRE-JOINT Frame Clamp



### *Special Jaws Available to Assure Perfect Clamping*

This bench unit is designed for clamping up frames as well as domes for cabinets and similar work. It is also used in many plants for mitred card table tops.

Pressure is applied by turning the handwheel, which operates a right- and left-hand screw. This moves the jaw plates towards the center, drawing up the joints. Each jaw mount plate has an individual, fine screw adjustment for setup. Jaws are supplied with adjustable plates to which small forms may be attached to fit the contour of the job being run. When plain frames are being clamped, these plates may be removed.

Special jaws can be supplied for a variety of work including octagon shape frames.

#### SPECIFICATIONS

##### No. 190 Handy Mitre-Joint Frame Clamp

Maximum Capacity: 30" x 30"

Minimum Capacity: 16" x 16"

Standard Jaws: Height—3½"  
Width—3⅞"

Approx. Wt.: 200 lbs.

*Machines with special dimensions can be supplied to meet any requirements.*

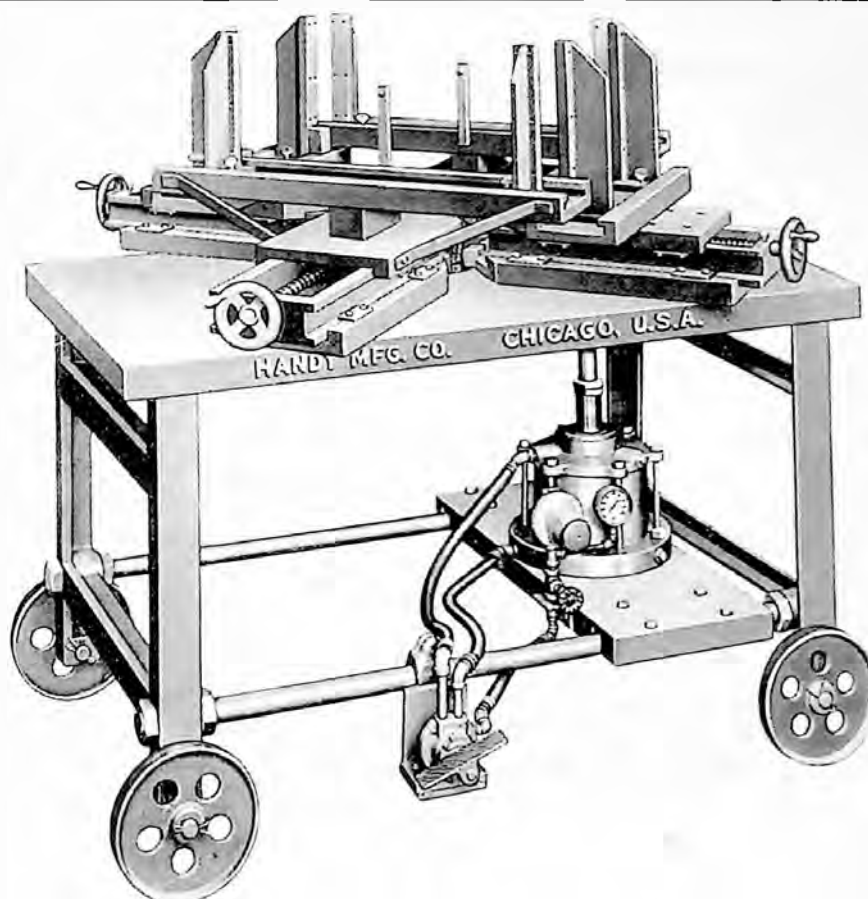
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No. **227**  
SERIES

## TRUE FOUR-WAY Box Clamps



### Perfect for Lock-Corner Boxes

The new Handy Air-Powered Box Clamp produces better grade boxes by a better principle with far greater accuracy and speed than ever before. To insure best results, clamping action is accomplished by movement of all four clamp-plates at once towards the center.

Setting up for the wide range of sizes possible is accomplished by rotating the four small hand-wheels and by sliding the two pressure bars on each clamp-plate so that pressure is applied near the end of each side of the box. These settings are then locked and, in production, only the pneumatic foot control is operated to draw up the boxes square and true. Clamp-plates and pressure bars operate on accurately machined ways.

#### SPECIFICATIONS

##### No. 229 Handy Air-Powered Box Clamp

Standard		Standard	Pressure Bars
Max. Capacity		Min. Capacity	Standard Hgt.
31" x 22"		8" x 5½"	9"
Standard Cylinders			Approx.
No.	Diam.	Stroke	Wt.
1	8"	1"	1400

Machines with special dimensions can be supplied to meet any requirements.

#### No. 227

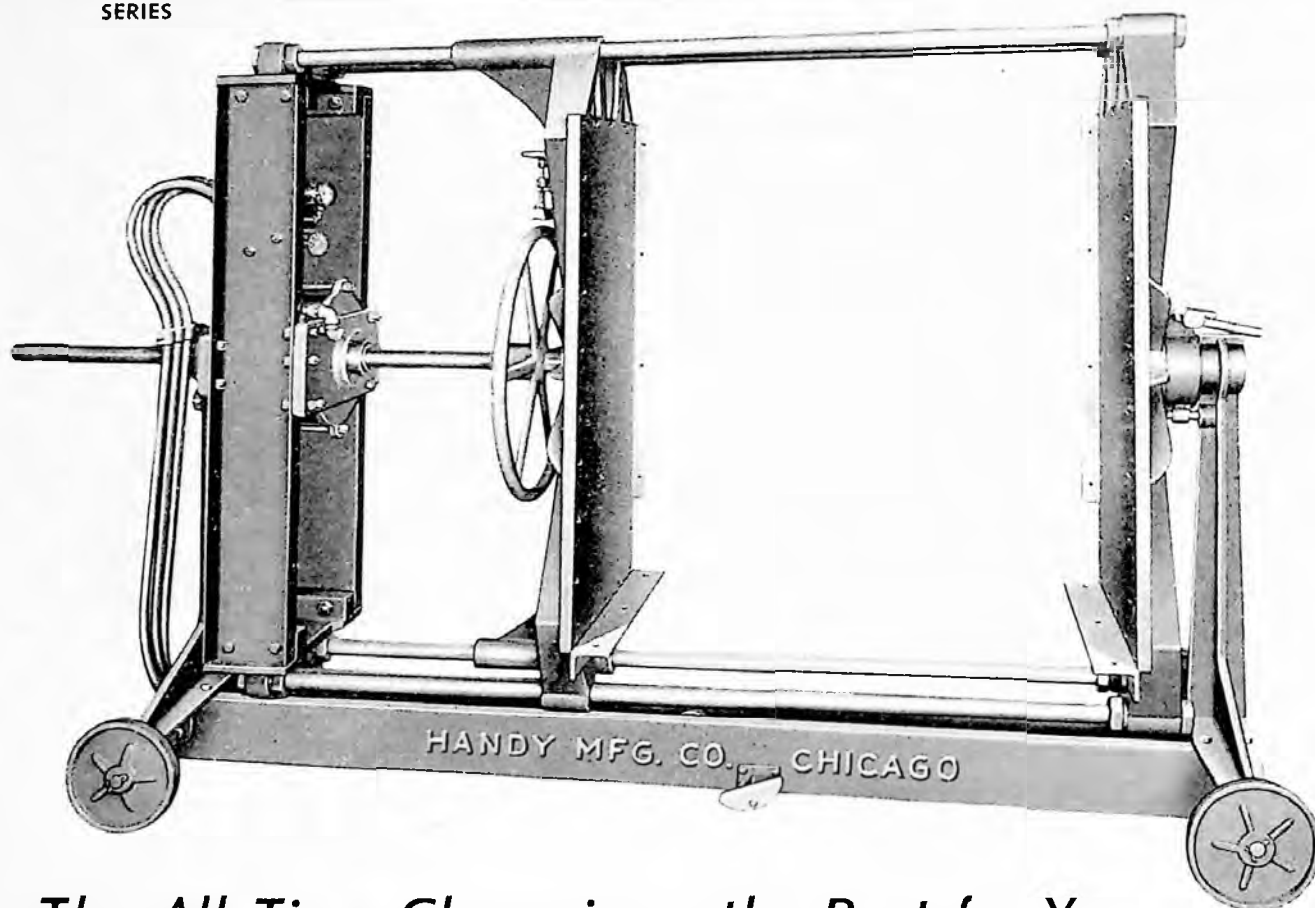
This unit is operated by a large foot pedal instead of by air power as in No. 229. The foot pedal is arranged with lock so that, if desired, the work may be held in the clamped position. Approx. Wt: 1200.

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **400**  
SERIES

## AIR-REVOLVING Case Clamps



### *The All-Time Champion—the Best for You*

With reason, Handy Air-Powered Case Clamps have been accepted as the proven standard equipment the world over. This is because they are properly engineered and properly made to do the job perfectly in making cases rapidly and well. Heavy castings, accurately machined, are a must—and Handy Case Clamps have them. Platforms and stops are provided to insure squaring and Handy design permits the greatest ease of control. Holes in clamp-plates are provided for special fillers or forms. Because of the Handy hollow-bore cylinder design, the oversize power unit does not move with the clamp-plate and undue strain is eliminated.

#### **EXCLUSIVE HOLLOW-BORE CYLINDER**

Through the use of an ingenious hollow-bore cylinder construction, ideal center-point pressure is obtained. Adjustment for case size is made by turning the handwheel operating the heavy screw which passes through the cylinder. Should air ever fail, these clamps stay in production as hand-operated units. Complete facilities are provided for perfect control of pressure and speed. The foot valve operates from both sides of the clamp.

*Additional data on next page*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.

# AIR-POWERED Case Clamps



No. **405**  
SERIES

## SPECIFICATIONS

No. 400A Series Handy Air-Powered Revolving Case Clamps							
No.	Clamp Plates Plated Surface	Hgt. Betw. Rods	—Standard—		—Cylinders—		Apprx. Wt.
			Max. Open.	Min. Open.	Diam.	Stroke	
400A	48" x 27"	59"	84"	25"	12"	2"	2700
401A	48" x 27"	59"	72"	20"	12"	2"	2650
402A	48" x 27"	59"	60"	15"	12"	2"	2600
403A	48" x 27"	59"	48"	15"	12"	2"	2550
404A	48" x 27"	59"	36"	10"	12"	2"	2500

Machines with special dimensions can be supplied to meet any requirements.

## SPECIAL CLAMP-PLATES

Handy Air-Powered Case Clamps, Series No. 400 and No. 405, can be supplied with clamp-plates in other sizes than type "A" which are 48"x27". These other sizes are:

Letter	Clamp Plates	Distance Between Rods
B	56" x 26"	66"
C	72" x 26"	75"
D	48" x 37"	59"
E	36" x 20"	41"

## Stationary Air Case Clamps

Handy Stationary Air-Powered Case Clamps are built with the same speed and ruggedness as the revolving units but omit the revolving feature.

## SPECIFICATIONS

No. 405A Series Handy Air-Powered Stationary Case Clamps							
No.	Clamp Plates Plated Surface	Hgt. Betw. Rods	—Standard—		—Cylinders—		Apprx. Wt.
			Max. Open.	Min. Open.	Diam.	Stroke	
405A	48" x 27"	59"	84"	25"	12"	2"	2400
406A	48" x 27"	59"	72"	20"	12"	2"	2350
407A	48" x 27"	59"	60"	15"	12"	2"	2300
408A	48" x 27"	59"	48"	15"	12"	2"	2200
409A	48" x 27"	59"	36"	10"	12"	2"	2100

Machines with special dimensions can be supplied to meet any requirements.

## Top Pressure Attachments

No. 395 Hand-Operated Screw Type Top Pressure attachment can be added to any Handy Case Clamp to provide top pressure. Several may be attached to each clamp.

No. 396 Air-powered Top Pressure Attachment for Handy Stationary Case Clamps provide ideal, fast, controlled top pressure. Supplied complete with pressure regulator, speed valve and control valve.

No. 397 Air-powered Top Pressure Attachment for Revolving Case Clamps, same as No. 396 but with counterweights.

## Fast, Powerful, Revolving

The revolving feature of this fine case clamp permits the work to be placed in the most convenient position for attaching corner blocks or doing any other work on the case or cabinet before removal from the clamp. The unit is well balanced, and a brake is provided to lock the clamp in any position.

## No. 394 Air-Power Revolving Unit for Revolving Case Clamps

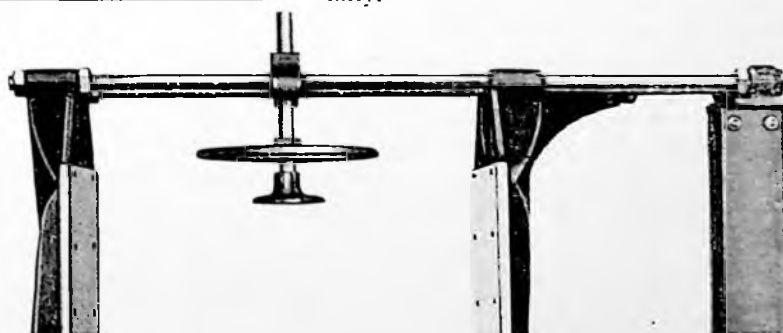
This Air Revolving Unit provides fast and virtually effortless means of revolving the clamp. Rotation can be in either direction, and optionally, dual controls are provided so that men must be at a safe distance before revolving can occur.

No. 394 with single control

No. 394D with dual control

## No. 398 Conversion Air Unit for Hand-Operated Clamps

Handy Screw Operated Case Clamps can be converted to air-powered units by the installation of the No. 398 Conversion Air Unit. When ordering, give diameter of rods and distance from center to center of rods both vertically and horizontally.



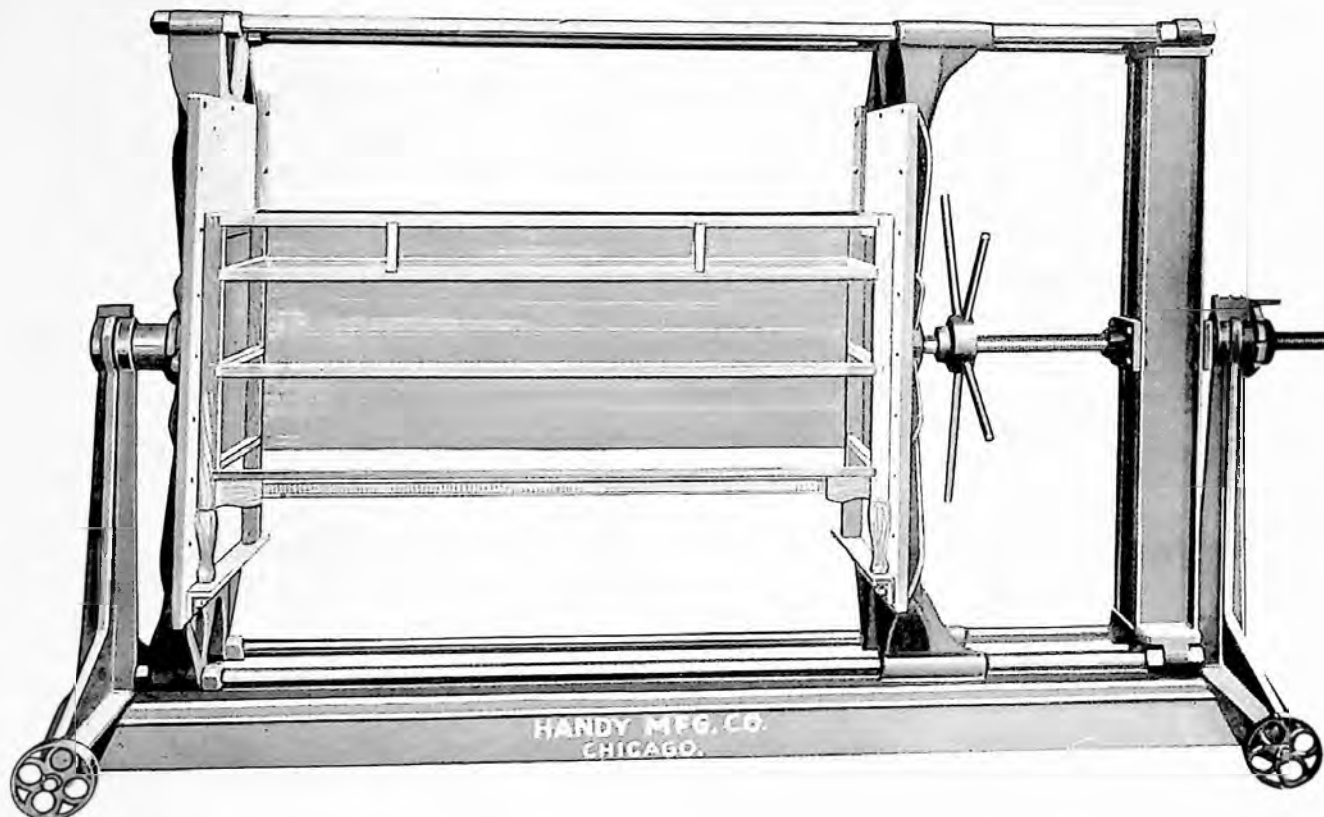
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No. **69**  
SERIES

# HAND-OPERATED Revolving Case Clamps



## For Decades—the Best

Handy Revolving Case Clamps are made the way a fine case clamp should be made. They are designed and built to assure quality production, absolutely square work, ease of operation, and to give years and years of superlative service. The clamp-plates are heavy castings, accurately machined to stay true forever. The larger diameter screw provides center pressure which is ideal for case goods production and the unit is easily revolved and locked, if desired, in any position for inserting corner blocks, driving screws or any other required operations on the case.

Each clamp-plate is equipped with steel platforms at the bottom and with holes near all four edges for attaching fillers and shapes.

Clamp-plates other than the standard 48" x 27", which are designated by suffix A, are available.

Plate Letter	Planned Surfaces—		Distance Between Rods
	Height	Width	
B	56"	26"	66"
C	72"	26"	75"
D	48"	37"	59"
E	36"	20"	41"

## SPECIFICATIONS

### No. 69 Series Handy Hand-Operated Revolving Case Clamps

No.	Planned Surface		Hgt. Betw. Rods	Max. Open.	Min. Open.	Approx. Wt.
	Height	Width				
69A	48"	27"	59"	84"	25"	2150
70A	48"	27"	59"	72"	20"	2125
71A	48"	27"	59"	60"	15"	2075
71½A	48"	27"	59"	48"	15"	2025
72A	48"	27"	59"	36"	10"	1950

Machines with special dimensions can be supplied to meet any requirements.

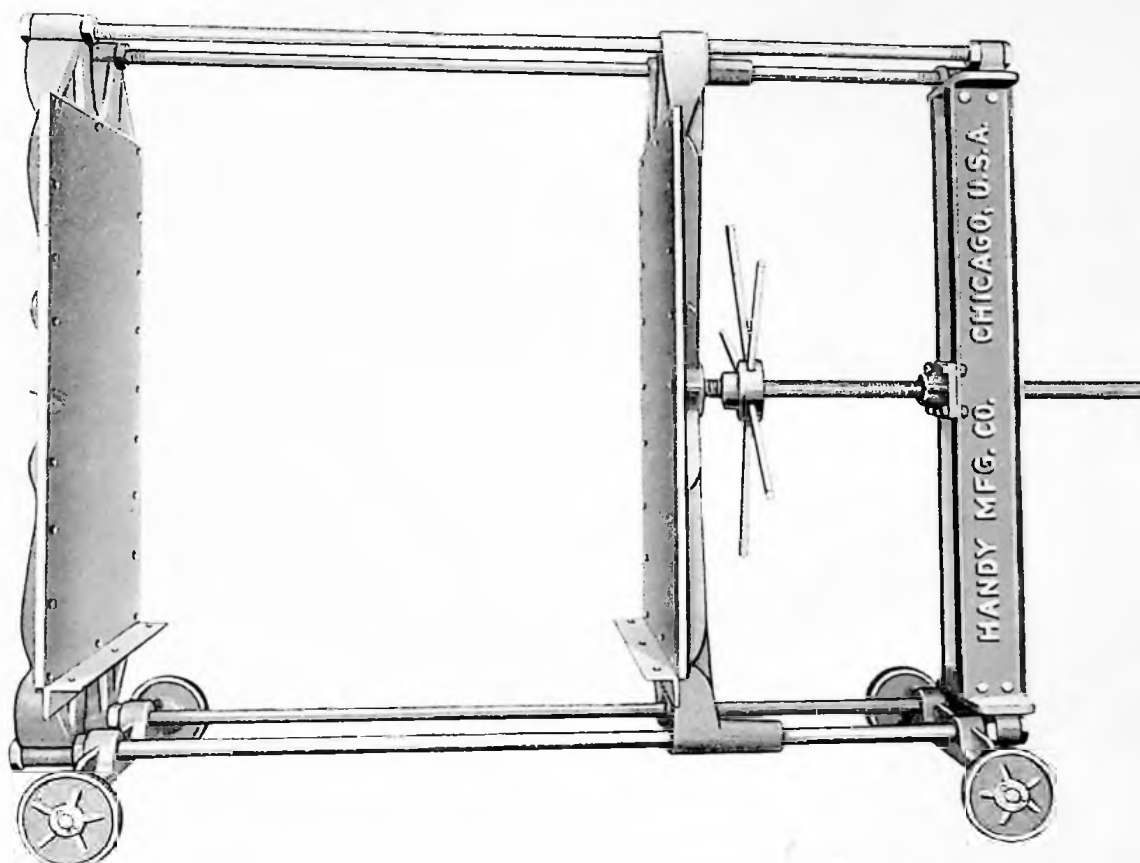
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CHICAGO 25 U. S. A.





No. 79  
SERIES  
No. 94

## HAND-OPERATED Stationary Case Clamps



Handy Hand-Operated Stationary Case Clamps incorporate heavy, accurately machined clamp-plates, rugged quick-acting acme thread screw and all necessary construction features to insure accurate clamping. The large sprocket wheel provides ample pressure. Steel platforms are provided on each of the clamp-plates and clamp-plates have drilled holes for attaching forms when necessary.

### No. 94

#### Low-Type Stationary Case Clamp

This clamp has clamp-plates 35" high and 48" wide and is built close to the floor so that a minimum amount of lifting is necessary in placing the work on the platforms which are located 7" from the floor. Maximum opening is 30", minimum 10". Additional opening add ■. Wt.: 2100 lbs.

Series No. 79 can be supplied with clamp-plates in sizes other than type "A" which are 48" x 27".

Letter	Clamp Plates	Hgt. Bet. Rods
B	56" x 26"	66"
C	72" x 26"	75"
D	48" x 37"	59"
E	36" x 20"	41"

### SPECIFICATIONS

#### No. 79A Series Handy Hand-Operated Stationary Case Clamps

No.	Clamp Plates Planed Surface		Hgt. Bet. Rods	Standard		Approx. Wt.
	Height	Width		Max. Open.	Min. Open.	
79A	48"	27"	59"	84"	25"	1950
80A	48"	27"	59"	72"	20"	1925
81A	48"	27"	59"	60"	15"	1875
81½A	48"	27"	59"	48"	15"	1825
82A	48"	27"	59"	36"	10"	1750

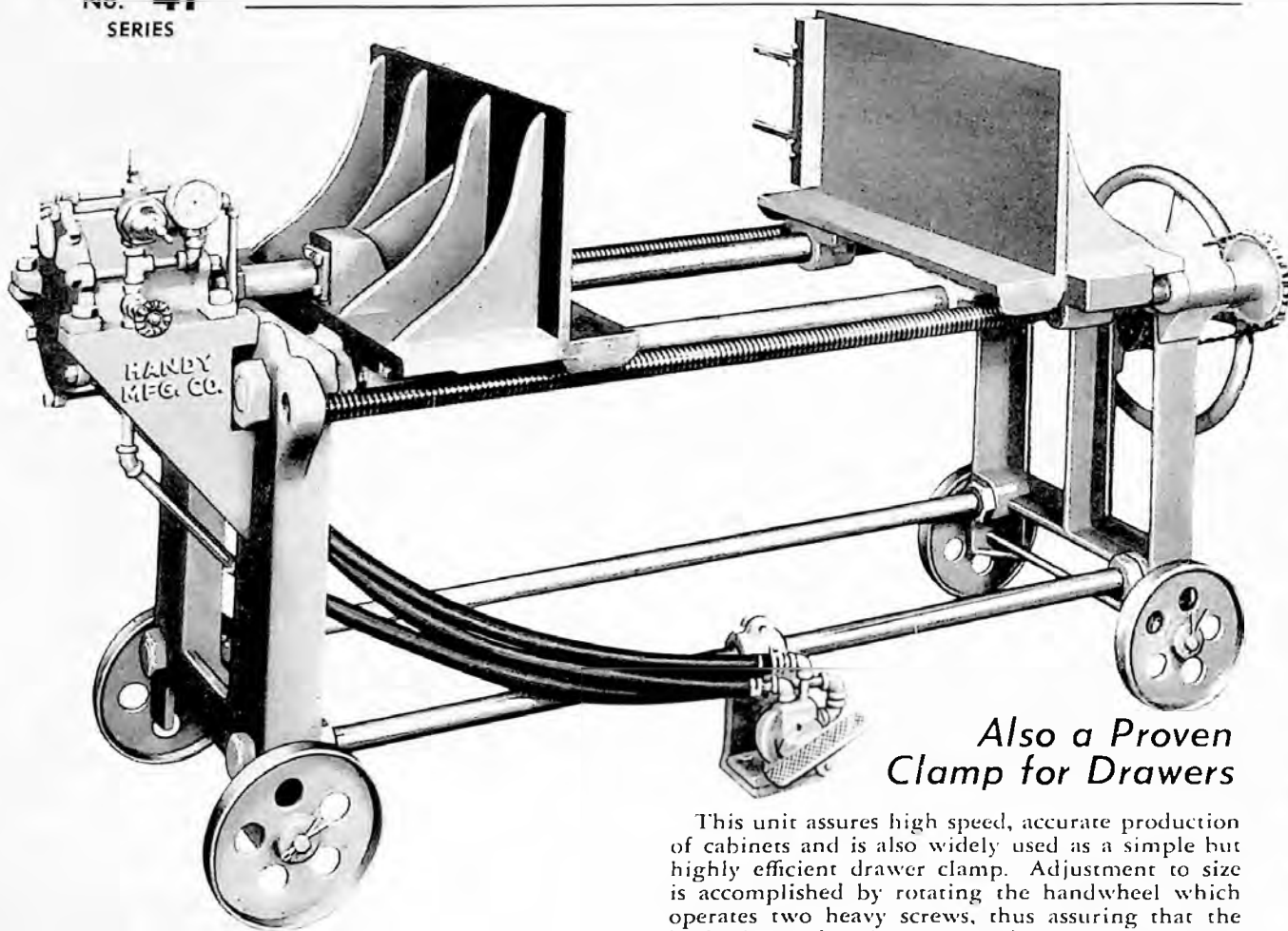
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No. **41**  
SERIES

## AIR-POWERED Cabinet Clamp



*Also a Proven  
Clamp for Drawers*

### HAND-OPERATED MODEL

No. 40 Handy Cabinet and Drawer Clamp, a screw operated unit, is similar to the No. 41 except that the clamp-plates are smaller and the movable clamp-plate is operated by a single crew.

#### SPECIFICATIONS

**No. 40 Handy Hand-Operated Cabinet and Drawer Clamp**

—Standard Clamp Plates—				
Height	Length	Max. Open.	Addl. Max. Open. Add	Approx. Wt.
10"	23"	30"	*	800

*Machines with special dimensions can be supplied to meet any requirements.*

#### SPECIFICATIONS

**No. 41 Handy Air Powered Cabinet and Drawer Clamp**

—Standard Clamp Plates—				Standard Cylinders			Approx. Wt.
Height	Length	Max. Open.	Addl. Max. Open. Add	No.	Diam.	Stroke	
12"	28"	30"	■	1	8"	2"	950

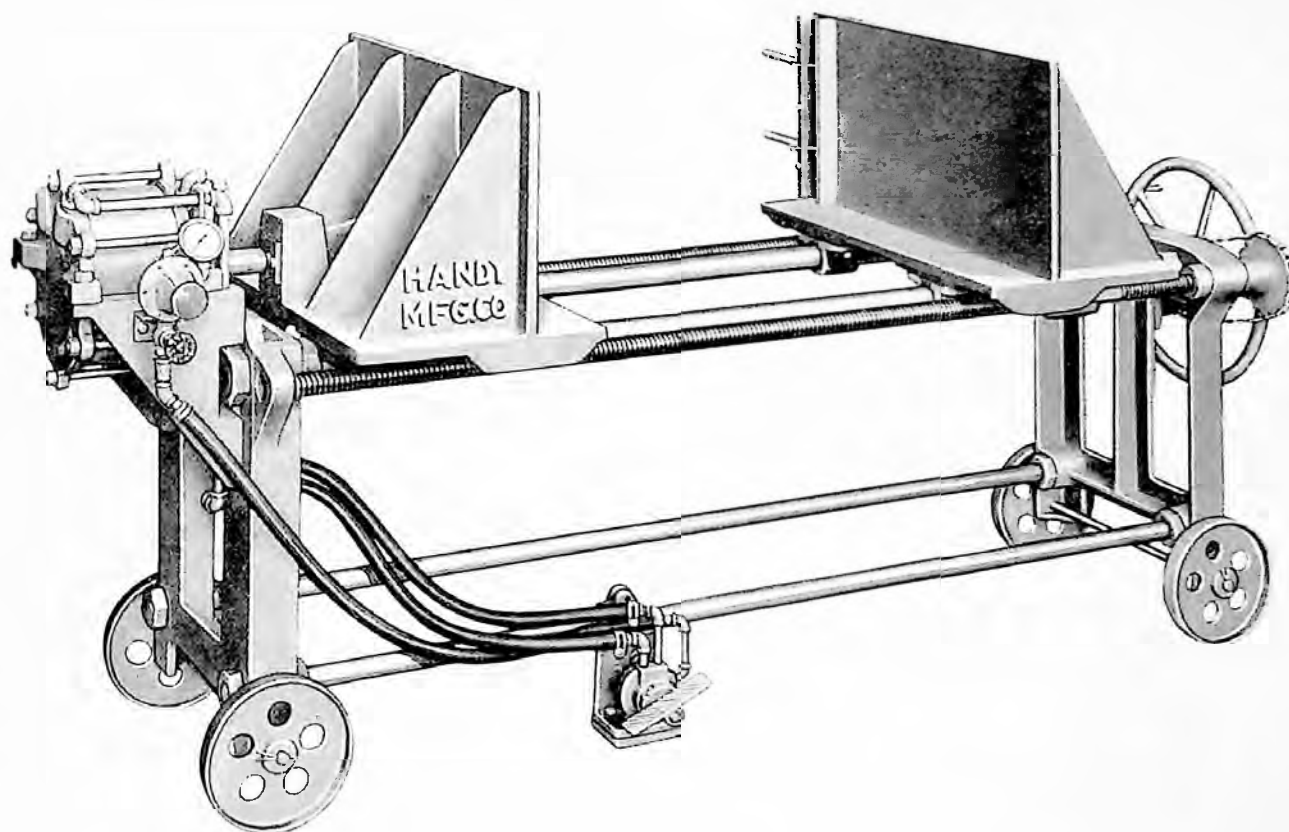
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. 50  
SERIES

## AIR-POWERED Cabinet Clamps



### Proven Producer of Fine Cabinets

Accurately machined cast clamp-plates are a necessity in the final assembly of good square cabinets. This unit provides these as well as fast setup and quick, accurate clamping for medium sized cabinets. Each clamp-plate is equipped with adjustable squaring stops. Adjustment for various sizes of cabinets is instantly made by turning the handwheel. Extra power is provided for dependable operation. The pressure regulator and gauge, speed and foot valve are conveniently located so that the operator can work with ease.

#### SPECIFICATIONS

##### No. 51 Handy Air-Powered Cabinet Clamp

Clamp Plates				
Height	Length	Max. Open.	Min. Open.	Add. Max. Open. Add
15"	30"	30"	10"	■
Standard Cylinders				Approx. Wt.
Number	Diameter	Stroke		
1	10"	2"		1300

*Machines with special dimensions can be supplied to meet any requirements.*

#### No. 50

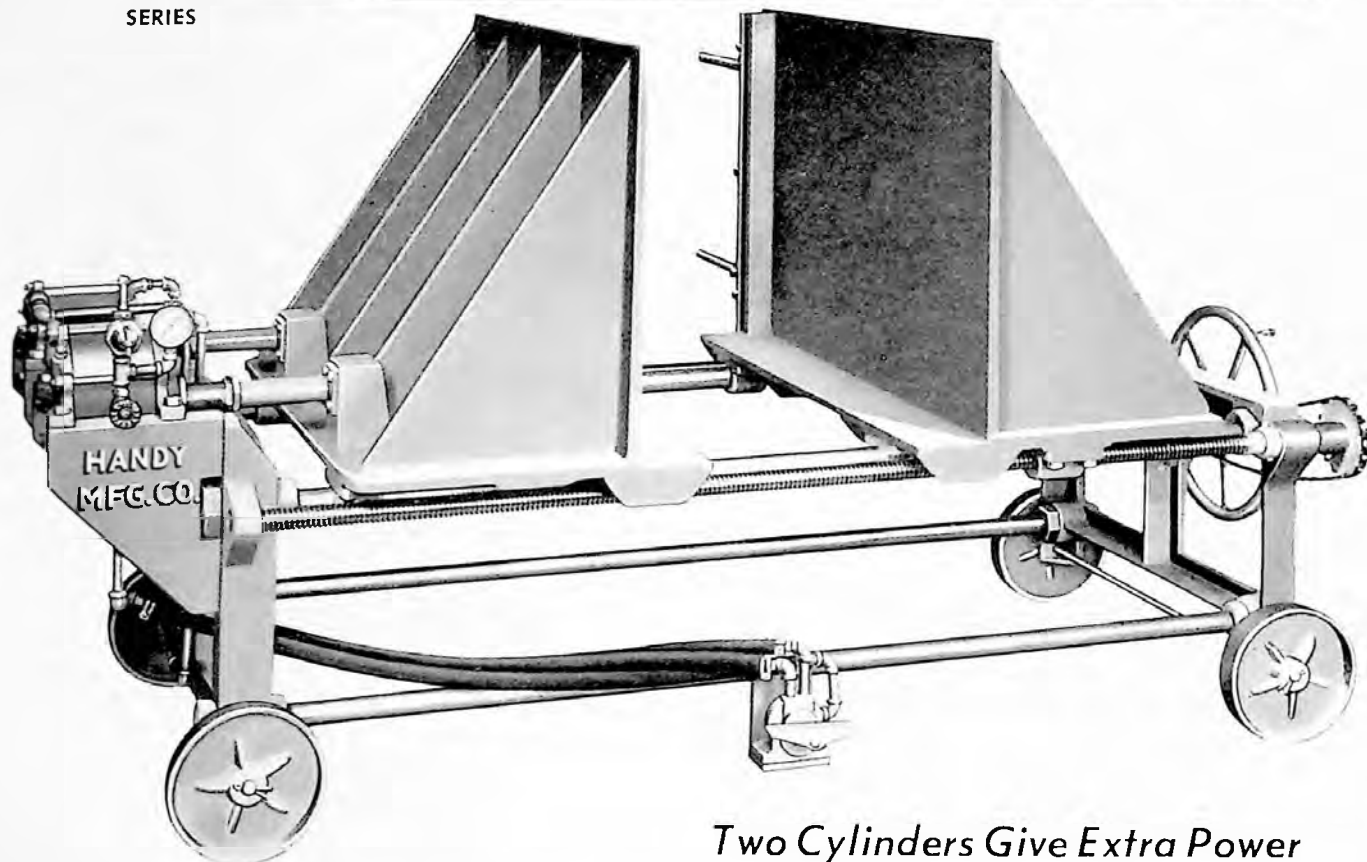
The same size screw operated cabinet clamp is called the No. 50. Capacity is the same and the movable clamp-plate is operated by a quick-acting screw with a large handwheel. Approx. Wt.: 1175.

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CHICAGO 25 U. S. A.



No. **61**  
SERIES

## AIR-POWERED Case Clamp



### HAND-OPERATED MODEL

No. 60 Handy Case Clamp is a hand-operated clamp for the same service as No. 61. Its construction is similar but the movable plate is operated by a single screw and large handwheel. The other plate is stationary at all times. Setup is fast and the unit is extremely rugged.

#### SPECIFICATIONS

No. 60 Handy Hand-Operated Case Clamp

Standard Clamp Plates			Addl. Max. Open. Add	Approx. Wt.
Height	Length	Max. Open.		
24"	45"	30"	■	2600

Machines with special dimensions can be supplied to meet any requirements.

### Two Cylinders Give Extra Power

This heavy-duty unit is ideal for production of cases and cabinets where revolving or center-pressure case clamps are not desired. Powered by two cylinders, pressure beyond the requirements of any job is assured. For setup, the adjustable clamp-plate is moved into position accurately by two screws operated by a single handwheel. Adjustable squaring stops are provided on each clamp-plate.

#### SPECIFICATIONS

No. 61 Handy Air-Powered Case Clamp

Standard Clamp Plates			Standard Cylinders			Approx. Wt.
Height	Length	Max. Open.	Max. Addl. Open.	Max. Addl. Open.	No. Diam. Stroke	
24"	45"	30"	■	■	2 8" 2"	2800

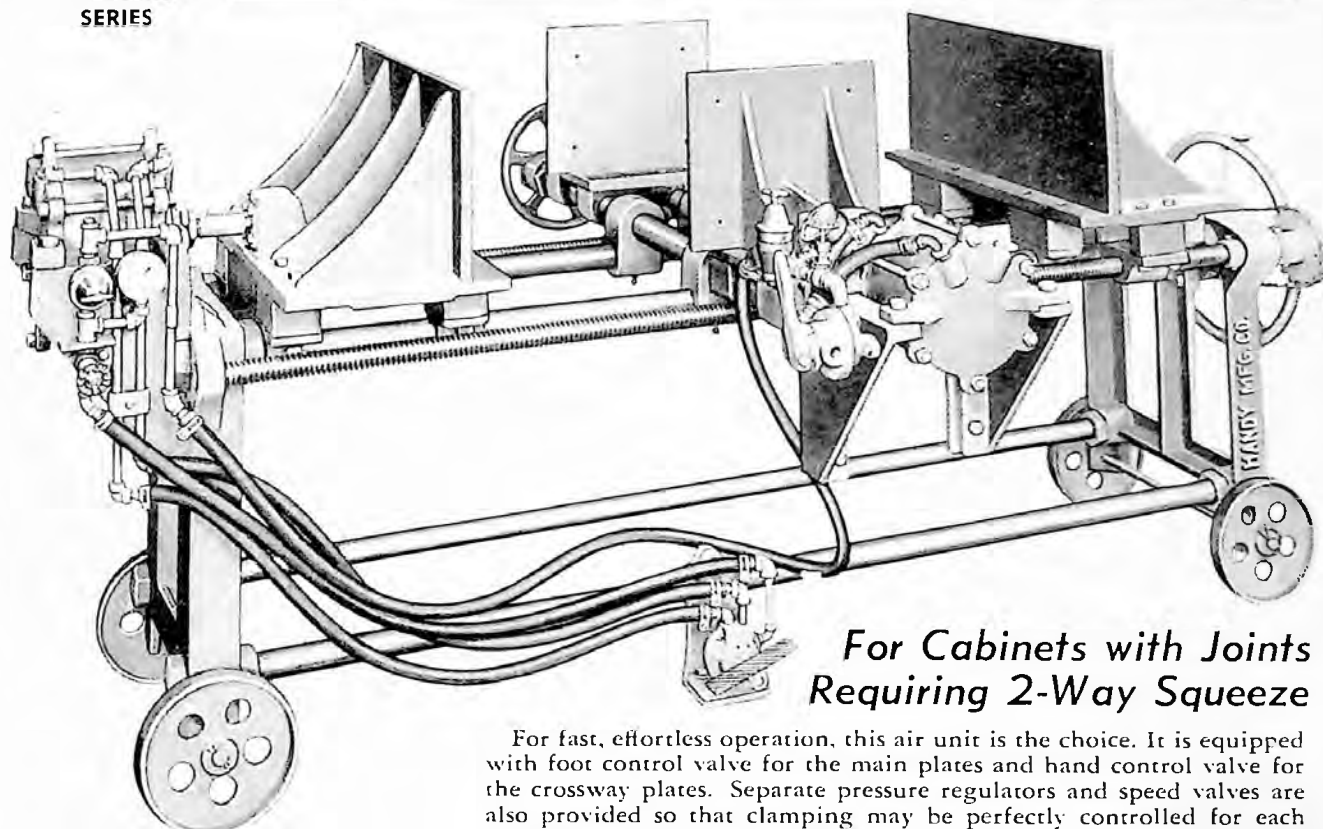
Machines with special dimensions can be supplied to meet any requirements.





No. **33**  
SERIES

## TWO-WAY Cabinet Clamps



### *For Cabinets with Joints Requiring 2-Way Squeeze*

For fast, effortless operation, this air unit is the choice. It is equipped with foot control valve for the main plates and hand control valve for the crossway plates. Separate pressure regulators and speed valves are also provided so that clamping may be perfectly controlled for each job. Handwheels are used only for adjustment to size in setup.

For any cabinet assembly requiring two-way pressure, this unit assures perfect squaring and maximum speed. Adjustments for size in both directions are quickly made so that a wide range of cabinet sizes may be run. Standard clamp-plates, which are 12" high, have holes so that special forms may be attached when required. The crossway clamp-plates are easily positioned at any desired location between the main clamp plates so that, regardless of size of cabinet, they may operate in the center.

#### SPECIFICATIONS

##### No. 34 Handy Air-Powered Two-Way Cabinet Clamp

Standard Clamp Plates				Standard Crossway Clamp Plates			
Lgth.	Hgt.	Max. Open.	Addl. Max. Open. Add.	Lgth.	Hgt.	Max. Open.	Min. Open.
28"	12"	24"		14"	12"	30"	7"
Standard Main Cylinder			Crossway Cylinder			Approx. Wt.	
No.	Diam.	Stroke	No.	Diam.	Stroke		
1	8"	2"	1	6½"	2"	1500	

*Machines with special dimensions can be supplied to meet any requirements.*

No. 33 Handy Hand-Operated Cabinet Clamp has a large wheel at the left end of the machine for the main plate and a smaller wheel on the front of the clamp to operate the crossway plate.

#### SPECIFICATIONS

##### No. 33 Handy Hand-Operated Two-Way Cabinet Clamp

Standard Clamp Plates				Standard Crossway Clamp Plates				Approx. Wt.
Lgth.	Hgt.	Max. Open.	Addl. Max. Open. Add.	Lgth.	Hgt.	Max. Open.	Min. Open.	
28"	12"	24"	*	14"	12"	30"	7"	1325

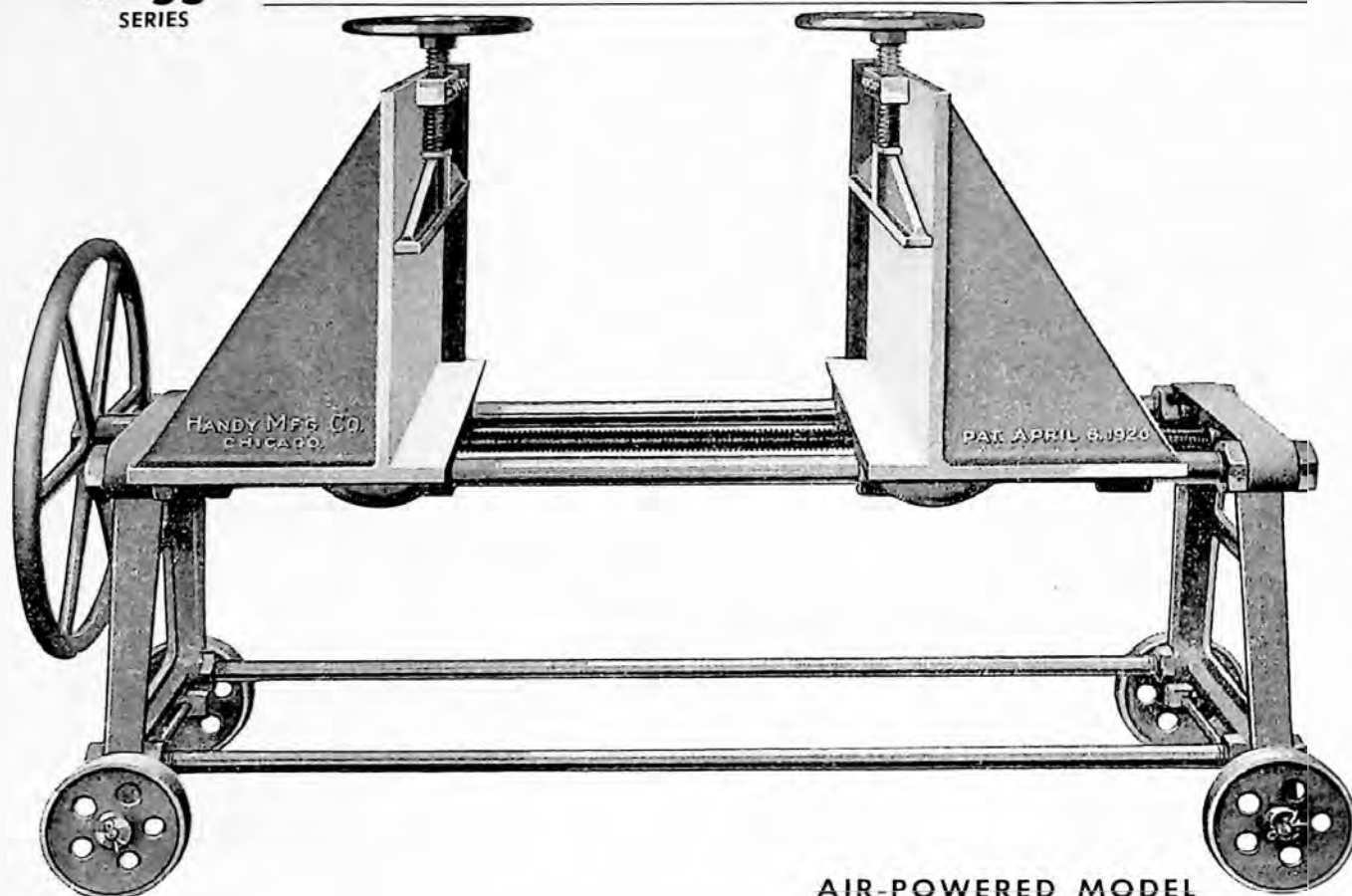
*Machines with special dimensions can be supplied to meet any requirements.*

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CHICAGO 25 U.S.A.



No. **53**  
SERIES

# TOP-PRESSURE Cabinet Clamp



This cabinet clamp is equipped with top-pressure attachments on each clamp-plate so as to provide two-directional pressure when required. Top-pressure units can be removed when not wanted and each clamp-plate is equipped with adjustable squaring stops.

These units can be supplied without top-pressure attachments and this type of top-pressure attachment can also be supplied for other size cabinet clamps.

## SPECIFICATIONS

### No. 53 Handy Top-Pressure Cabinet Clamp

Standard Clamp Plates		Lgth.	Max. Open.	Addl. Max. Open.		Approx. Wt.
Hgt. Under Top	Hgt. Pressure Attach.			Add	Star	
22½"	16"	30½"	30"	★		1300

Machines with special dimensions can be supplied to meet any requirements.

## AIR-POWERED MODEL

No. 57 Handy Air-Powered Cabinet Clamp is similar to No. 53 but provides the advantages obtainable with pneumatic operation. Instead of a single screw, the adjustable plate is provided with double screws and a single handwheel for adjustment. The opposite clamp-plate is air-powered.

## SPECIFICATIONS

### No. 57 Handy Air-Powered Cabinet Clamp

Standard Clamp Plates				Addl. Max. Open.	Approx. Wt.
Hgt. Under Top	Hgt. Pressure Attach.	Lgth.	Max. Open.		
22½"	16"	30½"	30"	■	
Standard Cylinders				Approx. Wt.	
No.	Diam.	Stroke			
1	10"	2"		1475	

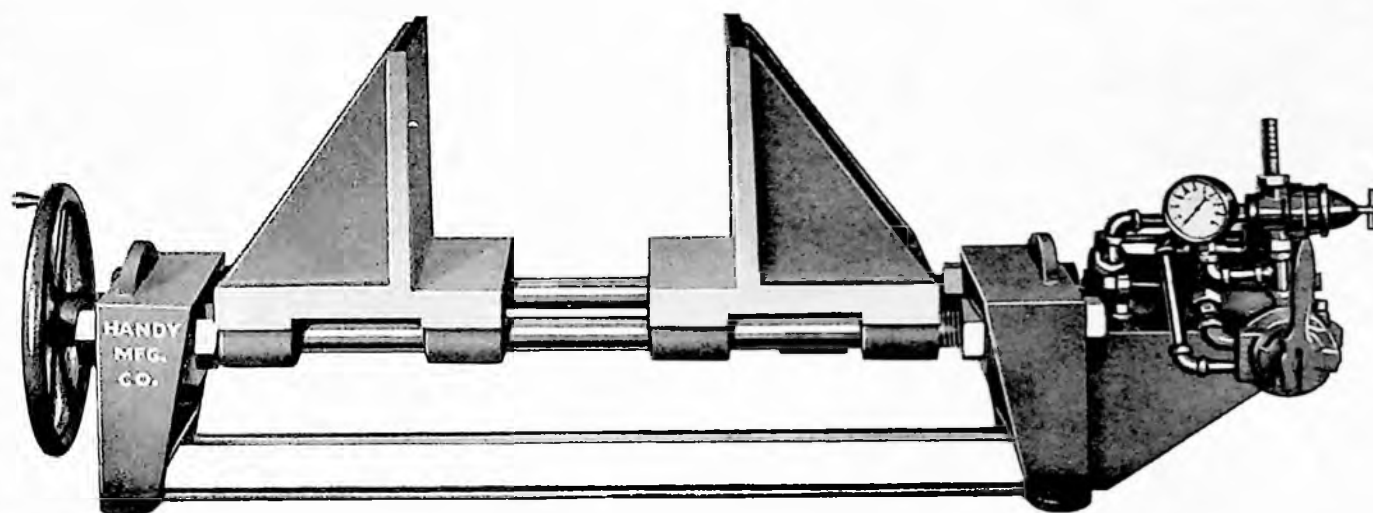
Machines with special dimensions can be supplied to meet any requirements.

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CHICAGO 25 U.S.A.



No. 435

## AIR-POWERED Bench Cabinet Clamp



### Fast Adjustment No Stops to Set

Quick and accurate, this utility cabinet clamp is designed for bench mounting. The powerful air cylinder is controlled by a hand valve conveniently located within easy reach of the operator. Since both pressure and speed can be regulated quickly to suit the job being done, perfect clamping is assured without dependency upon worker fatigue and judgment.

Adjustment to size is made by turning the hand-wheel, thus eliminating adjusting stops and the inaccuracy which results when stops wear.

Clamp-plates are extra heavy castings, accurately machined so that permanent trueness is assured even under the severest operating conditions. The unit is equipped with pressure regulator and gauge, speed control and hand valve.

### SPECIFICATIONS

#### No. 435 Handy Air-Powered Bench Cabinet Clamp

Standard Clamp Plates				Standard Cylinders			
Hgt.	Lgth.	Max. Open.	Addl. Open. Add	No.	Diam.	Stroke	Approx. Wt.
10"	12"	24"	*	1	6½"	2"	450

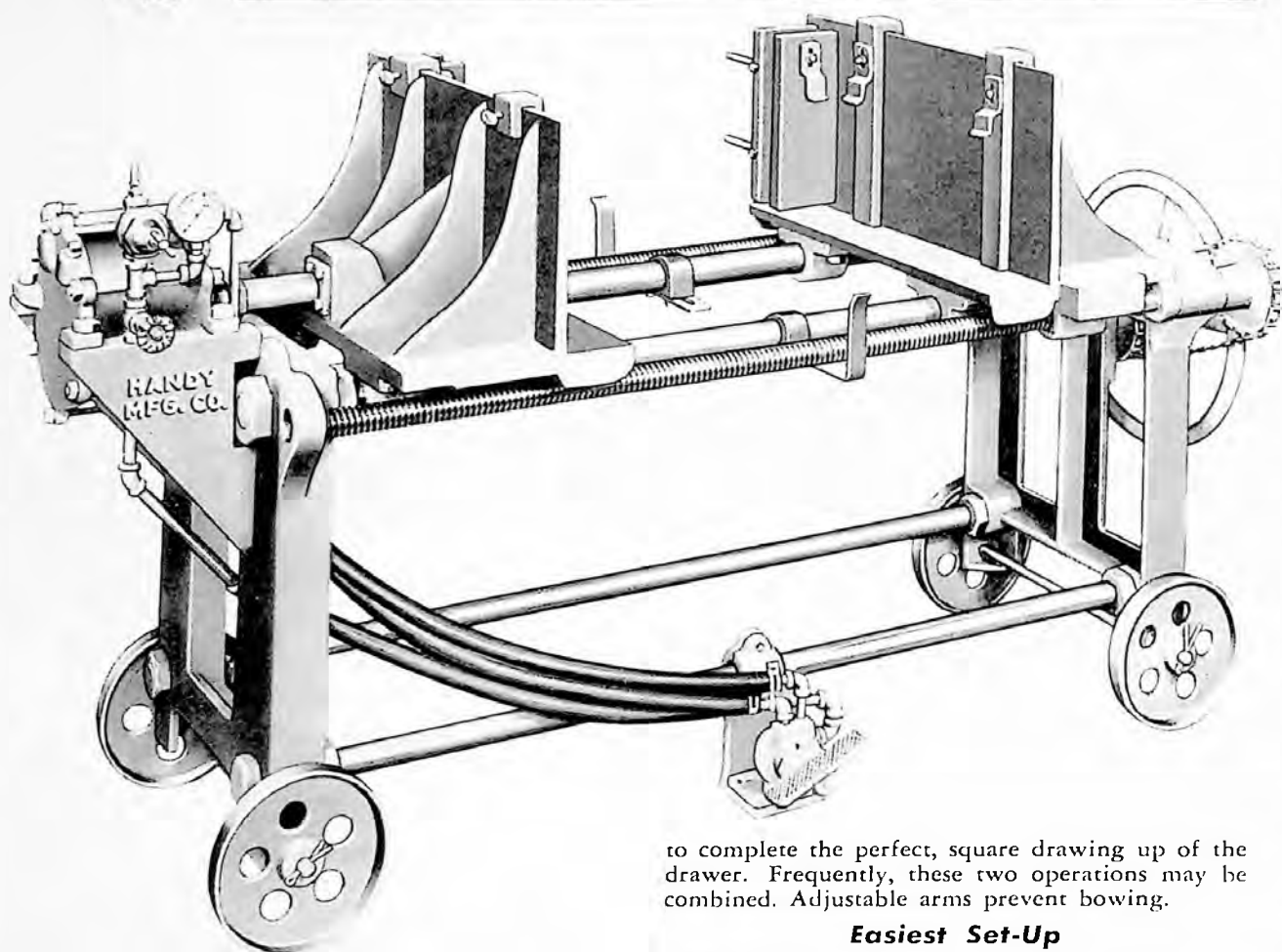
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U.S.A.



No. 43

## AIR-POWERED Drawer Clamp



### Best Clamp for Fastest Drawer Production

This newly designed unit provides the best and simplest drawer production for any method including complete assembly in the clamp in one or two operations. The squaring stops on each clamp-plate have adjustable fingers to receive and hold the drawer front. Adjustable fingers on the pressure bars hold the drawer sides in position until the first clamping stroke is made. The clamp is then opened and the drawer bottom and back positioned in the clamp. The clamp is closed again

to complete the perfect, square drawing up of the drawer. Frequently, these two operations may be combined. Adjustable arms prevent bowing.

#### Easiest Set-Up

No complicated setup is involved. The hand-wheel adjusts to drawer width, and fingers are set to drawer height. The movable bars are placed to apply pressure near the front and back of each drawer side. Bars clear a lip up to 1". Economical drawer production is of the greatest importance and here is the ideal unit for the job.

#### SPECIFICATIONS

No. 43 Handy Air-Powered Drawer Clamp						
Standard Clamp Plates				Standard Cylinders		
Lgth.	Hgt.	Max.	Max.	No.	Diam.	Stroke
		Open.	Open.			
26½"	12"	36"	■	1	8"	2"
Approx. Wt. 1025						
Machines with special dimensions can be supplied to meet any requirements.						

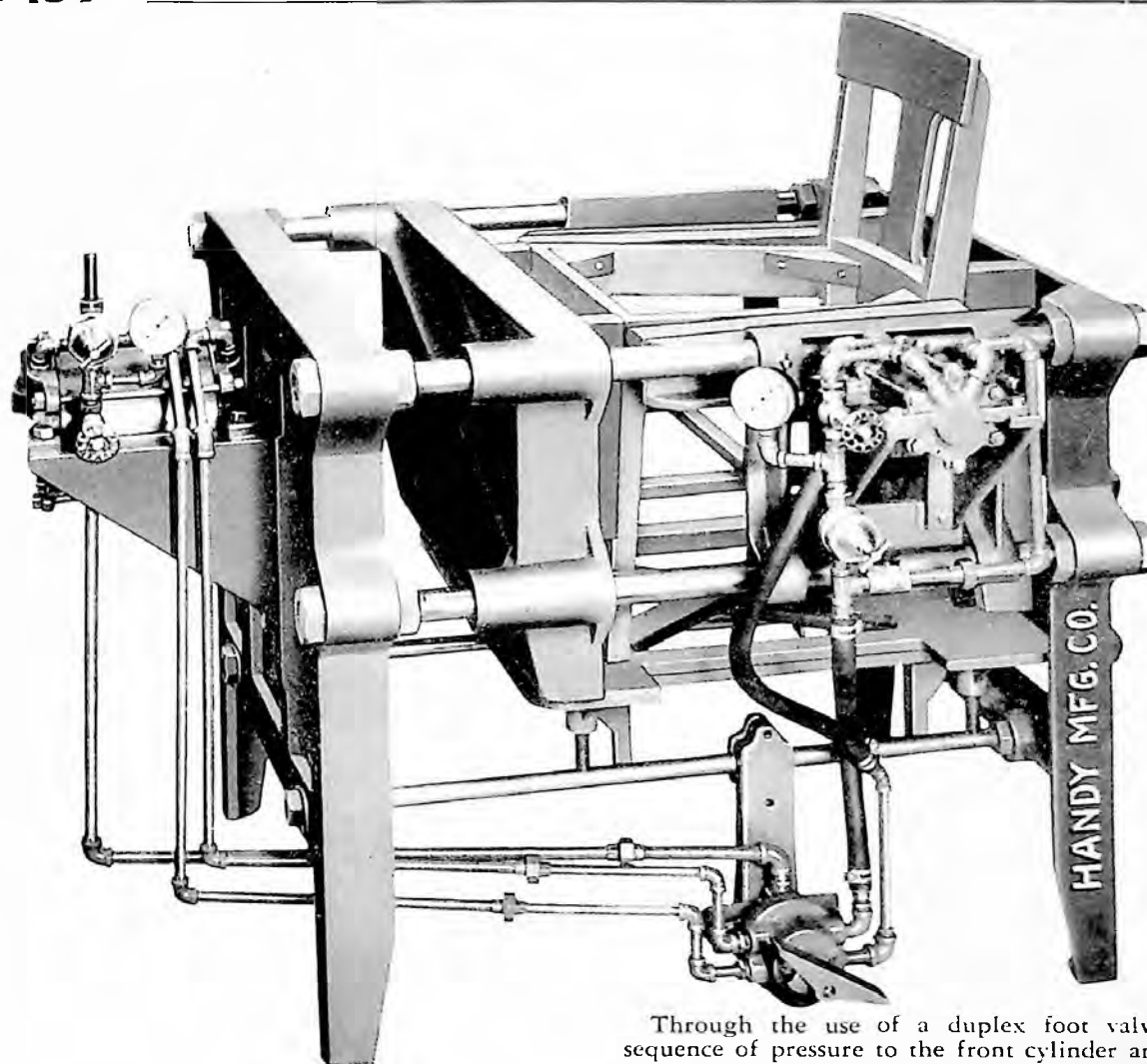
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CHICAGO 25 U. S. A.





No. 159

# AIR-POWERED Two-Way Chair Clamp



## Accurate and Fast

Wherever the greatest accuracy as well as the highest speed production is wanted, this air-powered two-way chair clamp is the answer. In addition to the major clamp-plates to draw up the joints, it is equipped with side pressure plates, adjustable in position, so that front and back sub-assemblies are perfectly aligned and perfectly centered every time.

As a result, with accurate machining, every chair will be exactly alike, thus avoiding loss of time in fitting chair seats.

Through the use of a duplex foot valve, the sequence of pressure to the front cylinder and side cylinder can be controlled as desired. In addition, both the speed and pressure of each cylinder may be adjusted to provide production perfection.

## SPECIFICATIONS

### No. 159 Handy Air-Powered Two-Way Chair Clamp

Capacity		Addl.		Standard Cylinders			Approx. Wt.
Width	Depth (front to back)	Depth	Add	No.	Diam.	Stroke	
25"	25½"	■		1	6½"	4"	1100
				1	3"	2"	

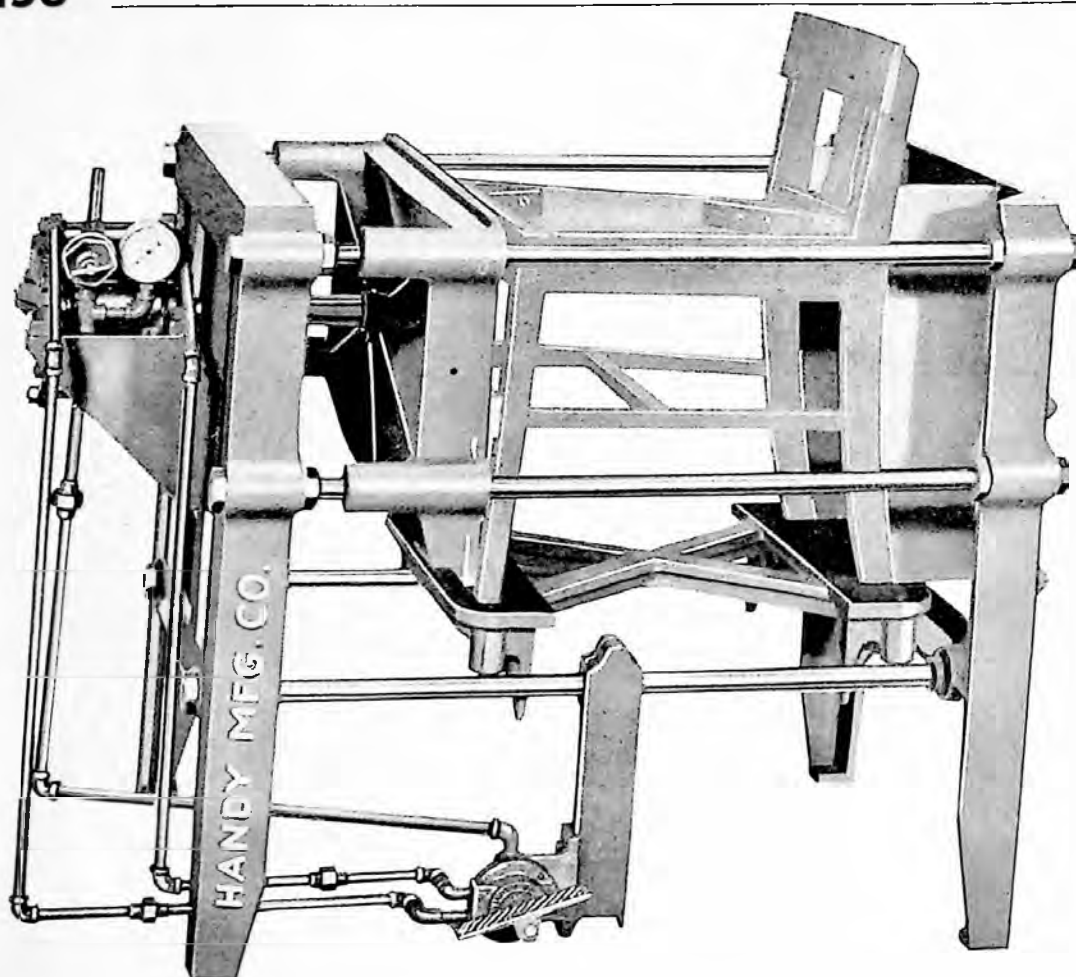
Machines with special dimensions can be supplied to meet any requirements.

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CHICAGO 25 U.S.A.



No. 158

## AIR-POWERED Speed Chair Clamp



### A Production Machine

Experts consider this highly efficient air-powered chair clamp essential for quantity chair production. It is so engineered that sub-assemblies placed in the clamp are quickly drawn up and the joints will be tight.

Since a foot valve is provided, both of the operator's hands are free to guide the work. The unit is built so that the chair is at the right height for conveniently installing corner blocks and doing other operations while the chair is held in the clamp.

Fill-in blocks to match the sweep of the chair are

easily installed and the platform on which the chair rests is provided with adjustments so that it can be positioned for the most efficient clamping.

The unit is equipped with pressure regulator and gauge, speed control and foot valve.

#### SPECIFICATIONS

##### No. 158 Handy Air-Powered Speed Chair Clamp

Width	Capacity Depth (front to back)	Addl. Depth Add	No.	Standard Cylinders Diam.	Stroke	Approx. Wt.
25½"	25½"	■	1	6½"	4"	800

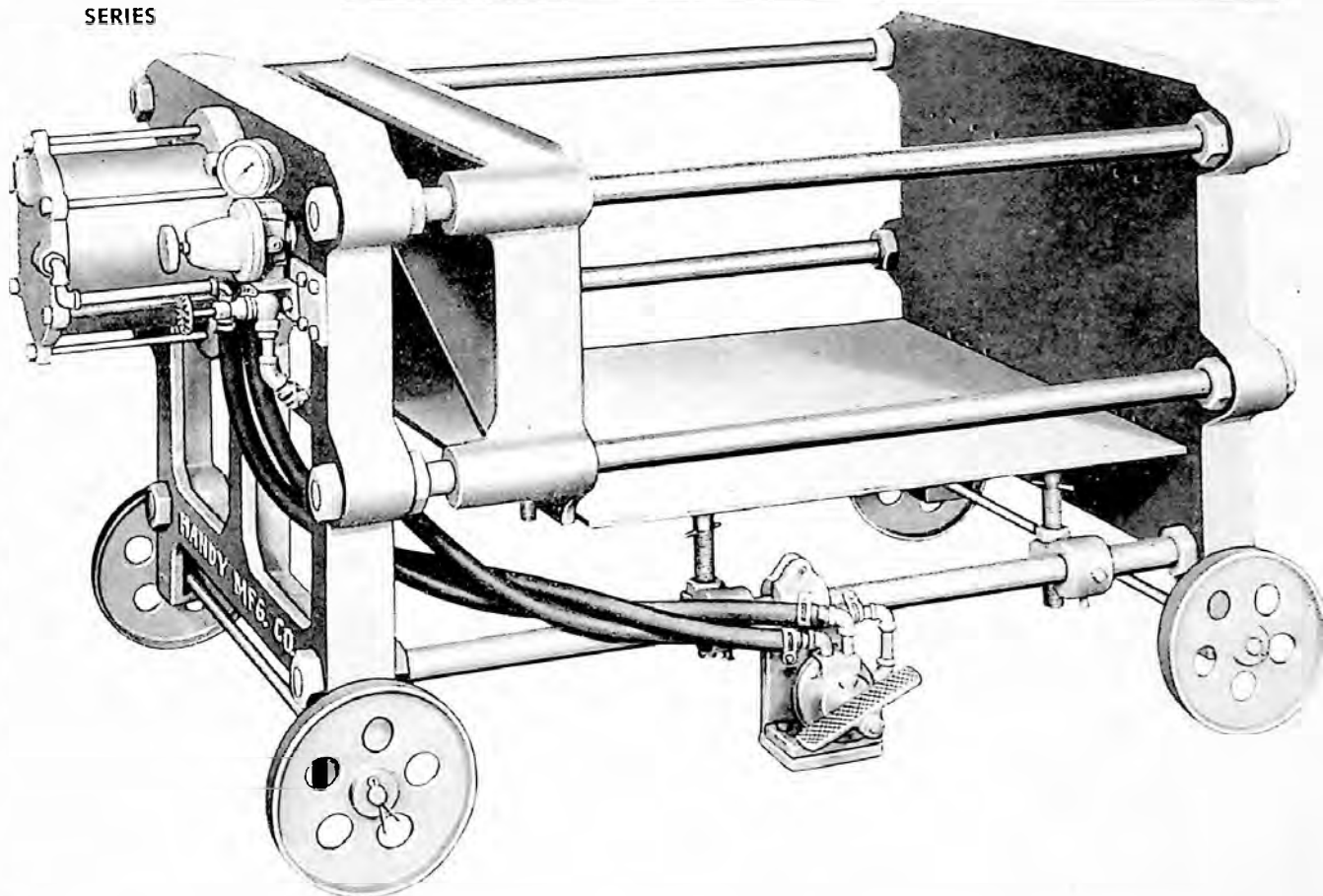
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY* Manufacturing Company  
CHICAGO 25 U. S. A.



No. **157**  
SERIES

## AIR-POWERED Large Chair Clamps



### *Easy, Fast Assembly of Large Pull-up Chairs*

This unit is designed for the fast assembly of larger chairs and has the advantage of speed and great accessibility. The chair to be clamped is at the correct height so that the worker may install corner blocks and attach arms while the chair is clamped. The adjustable floor plate of the clamp is placed at the correct position so that the seat is located at the top of the clamp-plates and so that pressure is properly applied to the chair frame. Wooden forms to match the sweep of the back leg are easily attached. Pressure regulator, speed valve and master control are located for the greatest ease of operation.

#### SPECIFICATIONS

##### No. 157 Handy Air-Powered Large Chair Clamp

Clamp Plates	Standard Opening	Addl. Open.	Air Cylinders			Approx. Wt.
			No.	Diam.	Stroke	
32½"	32½"	■	1	8"	4"	1275

*Machines with special dimensions can be supplied to meet any requirements.*

##### No. 156 Hand-Operated Chair Clamp

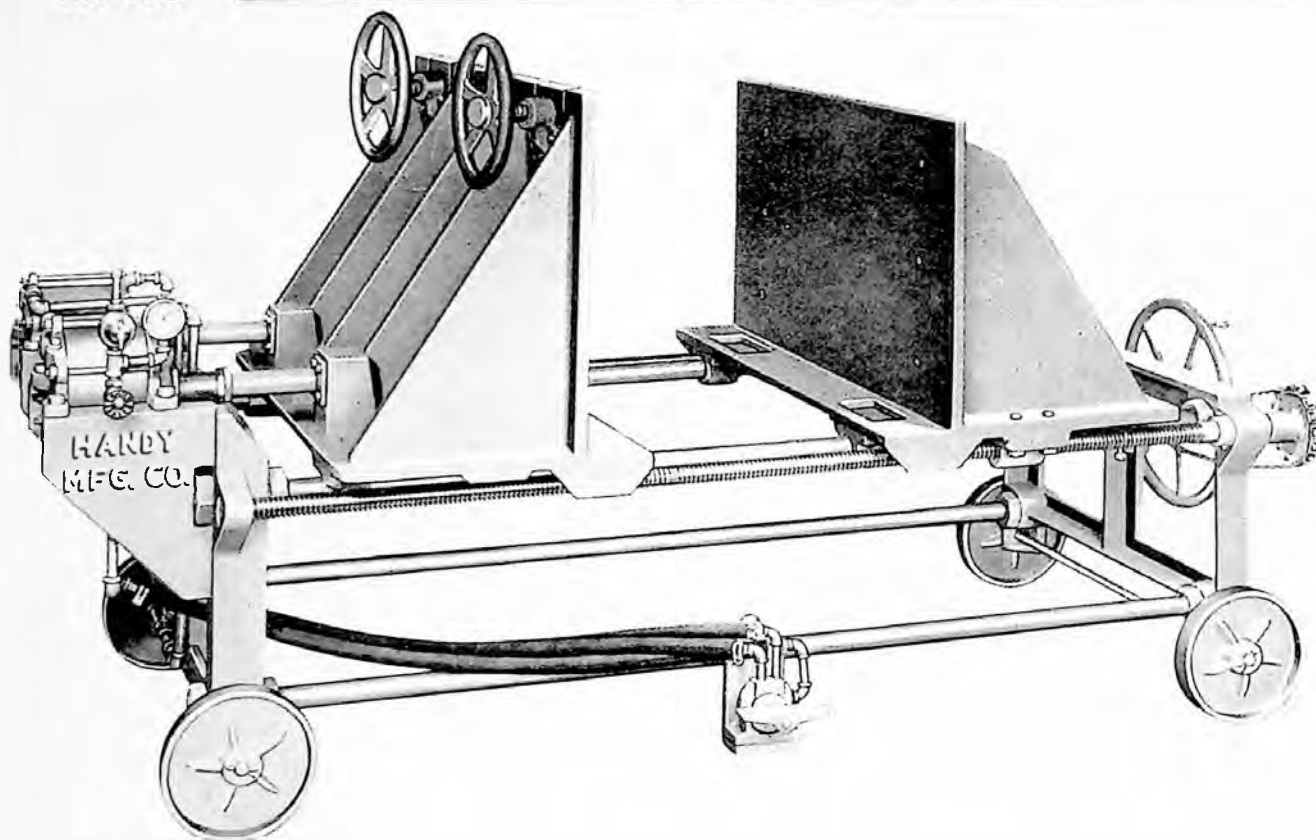
This clamp has the same capacity as the No. 157 but air operation is replaced by a heavy acme-thread screw rotated by a handwheel. The clamp-plate is thus rapidly moved into position and ample pressure provided for accurate clamping of chairs. No. 156 Approx. Wt.: 1150 lbs.

*HANDY Manufacturing Company*

CHICAGO 25 U. S. A.



## AIR-POWERED Chair Frame Clamp



### For Better, Faster Making of Upholstered Chairs

This powerful machine is designed primarily for clamping upholstered chair frames or any large chair. It is especially designed with holes in the low clamp-plate so that the legs of the chair may extend below the clamp surface. Holes, unless otherwise specified, will accommodate chairs measuring 20" to 24" between the inside of the back legs. This plate has holes for attaching forms to match the sweep of the chair back.

The air-powered clamp-plate is equipped with two auxiliary pressure blocks operated by hand-wheels which may be used to close the joints when any frame or parts have not been held to correct dimension. Unless otherwise specified, these pressure plates are mounted with their centers 29" apart. The height of the clamp surface from the floor is 24" which, together with the open construction of this unit, makes it easy to block or nail.

Full control is provided by foot pedal, speed valve, pressure regulator and gauge.

#### SPECIFICATIONS

##### No. 55 Handy Air-Powered Chair Frame Clamp

Large Clamp Plate		Small Clamp Plate		Max. Stand.	—Air Cylinders—			Approx.
Hgt.	Lgth.	Hgt.	Lgth.	Open.	No.	Diam.	Stroke	Wt.
18½"	38"	15½"	38"	38"	2	8"	2"	1650

Machines with special dimensions can be supplied to meet any requirements.

##### Hand-Operated Chair Frame Clamp

This clamp has the same capacity and construction as the No. 55 except that the large clamp-plate is operated by a pressure screw controlled by a handwheel. No. 54 Handy Hand-Operated Chair Frame Clamp. Approx. Wt.: 1400.

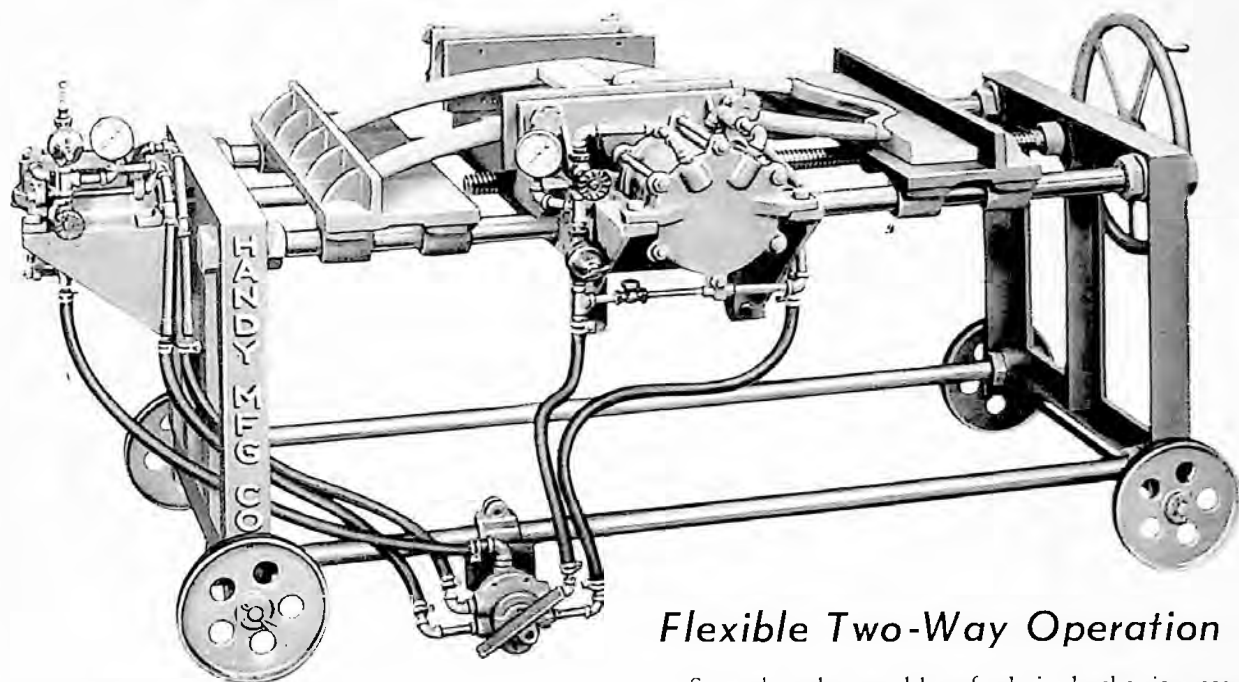
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No. 230

## AIR-POWERED Chair Back Clamp



### HAND-OPERATED MODEL

No. 210 Handy Chair Back Clamp, hand-operated, is similar to the No. 230 in construction except that, in place of cylinders, two screws operated by hand-wheels are provided. Construction is such that the chair back is placed in the clamp with the sweep downward instead of upward as in the No. 230.

Clamp-plates have drilled holes for attaching stops or shapes. Bottom stops are provided to adjust for sweep of chair.

### SPECIFICATIONS

#### No. 210 Handy Hand-Operated Chair Back Clamp

Length	Addl. Lgth. Add	Width, Max.	Width, Min.	Approx. Wt.
48"	★	24"	14"	600

*Machines with special dimensions can be supplied to meet any requirements.*

### Flexible Two-Way Operation

Smooth sub-assembly of chair backs is accomplished routinely with this adaptable unit. Because correct pressure, ideal sequence of pressure in each direction and the proper clamping speed are provided, good results are sure. Adjustments are provided for various lengths and widths. The side clamp-plates are adjustable for angle and position so as to properly apply pressure.

In addition to individual adjustment of speed and pressure, the sequence of the end pressure and side pressure are controlled by the duplex foot valve.

### SPECIFICATIONS

#### No. 230 Handy Air-Powered Chair Back Clamp

Length	Addl. Lgth. Add	Width, Max.	Width, Min.
48"	■	24"	14½"
Standard Cylinders			
No.	Diam.	Stroke	Approx. Wt.
2	6½"	4" & 2"	1260

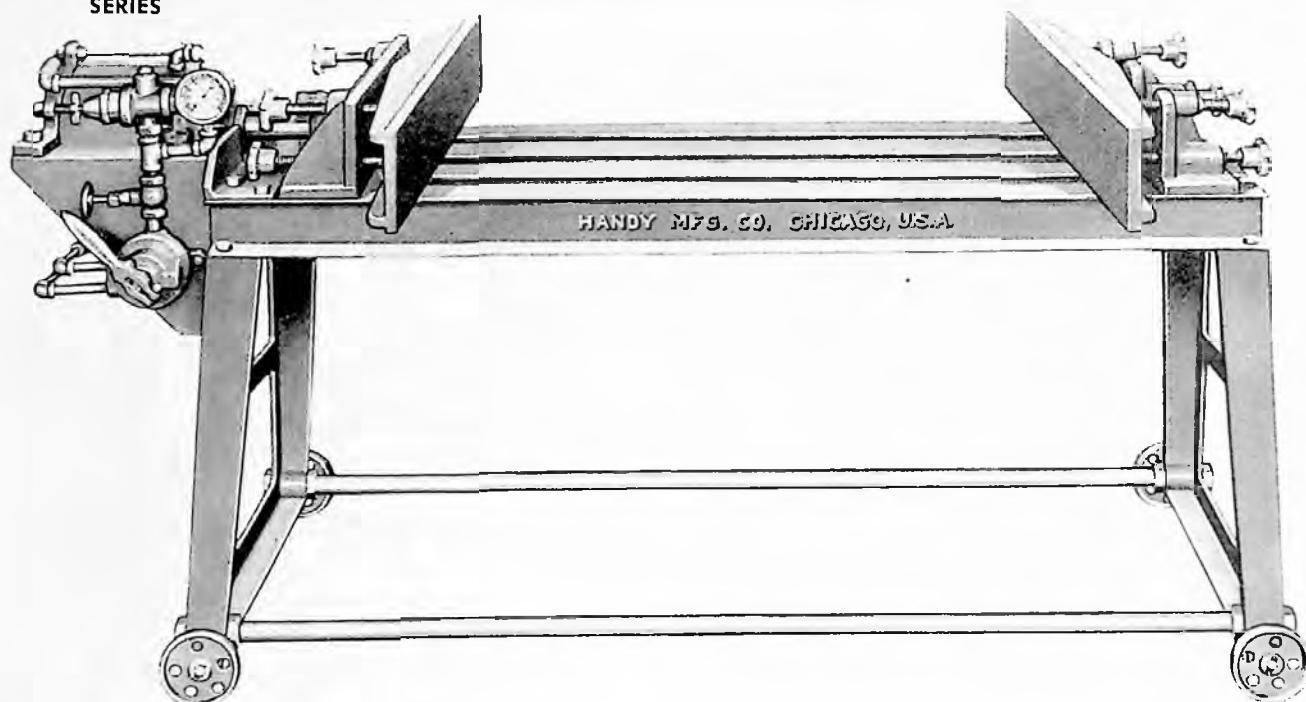
*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **214**  
SERIES

## CHAIR PARTS **Assembly Clamps**



### *For Clamping Chair Fronts and Stretchers and Other Flared Sub-Assemblies*

This series of clamps has clamp-plates which are adjustable to the flare of chair posts and may likewise be tilted forward or backward to conform to special contours. As a result, wood shapes or fillets may usually be dispensed with. These units have a planed bed 14" wide. Four models are available so that the correct unit for any plant may be selected.

#### **HAND-OPERATED**

In these clamps the pressure is applied by a quick-acting screw with a handwheel.

#### **SPECIFICATIONS**

##### **Handy Hand-Operated Chair Parts Assembly Clamps**

No. 214 Floor Model Clamp Plates	No. 215 Bench Model Clamp Plates
Length: 26", Height: 5"	Length: 26", Height: 5"
Stand. Max. Open.: 36"	Stand. Max. Open.: 36"
Addl. Max. Open. Add ■	Addl. Max. Open. Add ■
Approx. Wt.: 550	Approx. Wt.: 400

*Machines with special dimensions can be supplied to meet any requirements.*

Whether the need is for the most modern air-powered floor model illustrated or for bench model or hand-operated floor or bench clamps, one of the four types is available to suit your needs.

#### **AIR-POWERED**

The No. 216 and No. 217 air-powered units are equipped with Hand Control valve, pressure regulator and gauge, and speed valve. Fast uniform clamping pressure assures the best possible production.

#### **SPECIFICATIONS**

##### **Handy Air-Powered Chair Parts Assembly Clamps**

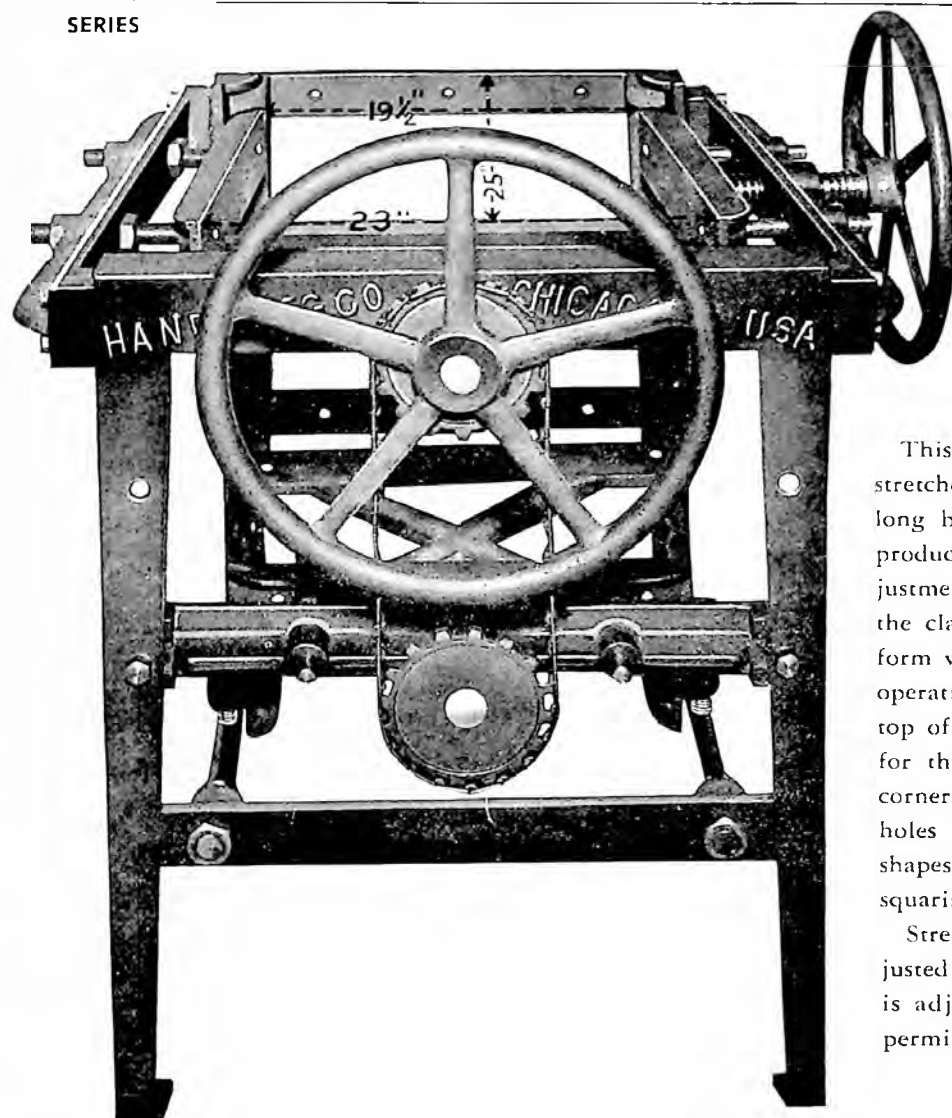
No. 216 Floor Model Clamp Plates	No. 217 Bench Model Clamp Plates
Length: 26" Height: 5"	Length: 26" Height: 5"
Stand. Max. Open.: 36"	Stand. Max. Open.: 36"
Addl. Max. Open. Add ■	Addl. Max. Open. Add ■
Air Cylinder	Air Cylinder
Diam.: 6½", Stroke: 2"	Diam.: 6½", Stroke: 2"
Approx. Wt.: 650	Approx. Wt.: 500

*Machines with special dimensions can be supplied to meet any requirements.*



No. **140**  
SERIES

## HAND - OPERATED Two-Way Chair Clamp



*Stretcher  
Clamping  
Attachment  
Optional*

This two-way chair clamp with stretcher clamping attachment has long been known for its efficient production of quality chairs. Adjustment is provided for each of the clamp-plates and for the platform which supports the chair. In operation, the chair seat is at the top of the clamp making it easier for the operator to screw on the corner blocks. Pressure plates have holes to permit the attaching of shapes or forms. Side pressure makes squaring certain.

Stretcher attachment can be adjusted to give desired pressure and is adjustable in height so as to permit pressure at the proper level.

Handy No. 140 Two-Way Chair Clamp is the same as No. 141 except the stretcher attachment is omitted.

### SPECIFICATIONS

#### No. 140 Handy Hand-Operated Two-Way Chair Clamp Without Stretcher Attachment

Width (across front)	Width (across back)	Depth (front to back)	Approx. Wt.
23"	19 1/2"	25"	500

*Machines with special dimensions can be supplied to meet any requirements.*

### SPECIFICATIONS

#### No. 141 Handy Hand-Operated Two-Way Chair Clamp With Stretcher Attachment

Width (across front)	Width (across back)	Depth (front to back)	Approx. Wt.
23"	19 1/2"	25"	580

*Machines with special dimensions can be supplied to meet any requirements.*

*HANDY Manufacturing Company*  
CHICAGO 25 U.S.A.



No. **150**  
SERIES

# HAND-OPERATED Chair Clamp

When side clamping pressure is not desired, this unit is recommended for efficient manual clamping of chairs. The platform on which the chair rests is adjustable forward and backward as well as up and down. Likewise the amount of pressure of the stretcher attachment can be adjusted and it is possible to apply pressure at the most desirable level. The handwheel operates simultaneously the top pressure plate as well as the stretcher pressure plate. Open design of this unit prevents accumulation of glue and dirt.

## SPECIFICATIONS

### No. 151 Handy Hand-Operated Chair Clamp With Stretcher Attachment

Capacity		Depth Front to Back	Addl. Depth Add	Approx. Wt.
Width Front	Width Back			
25½"	24"	25½"	★	505

*Machines with special dimensions can be supplied to meet any requirements.*

### Also Available Without Stretcher Attachment

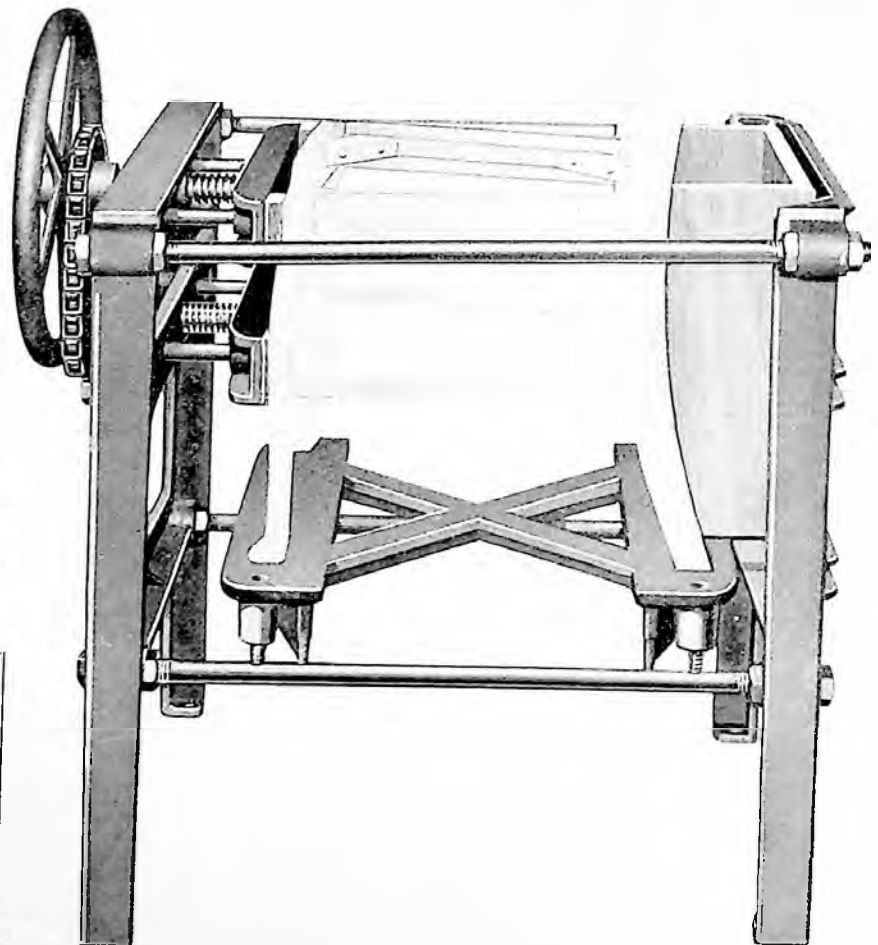
Handy No. 150 Chair Clamp is the same as No. 151 except that stretcher clamping attachment is omitted.

## SPECIFICATIONS

### No. 150 Handy Hand-Operated Chair Clamp Without Stretcher Attachment

Capacity		Depth Front to Back	Addl. Depth Add	Approx. Wt.
Width Front	Width Back			
25½"	24"	25½"	★	425

*Machines with special dimensions can be supplied to meet any requirements.*

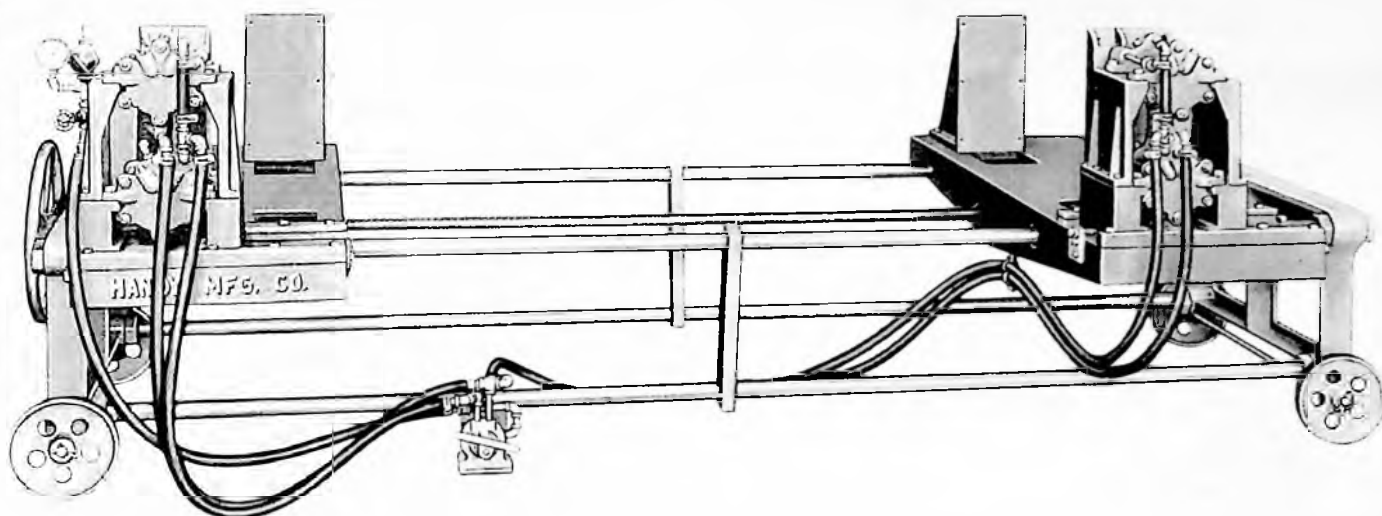


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No. **64**

## AIR-POWERED Sofa and Chair Clamp



### *An Improved Method for Clamping Upholstered Frames*

This clamp has proven to be the only efficient, high production method for clamping sofa, davenport and settee frames. The accurately machined tables are 18" wide so that special fixtures can be mounted to accommodate special shaped frames. Adjustment for length of frame is made by the handwheel and the two tables may be brought together so that chairs as well as sofas may be run in this clamp. Both front clamp-plates, which are 18" high by 6" wide, slide out of the way as shown at the left of the illustration so frames may be easily removed. The back plates are 15" high and 8" wide. Holes in the table are provided for legs to drop below the surface. The operator does all nailing and blocking with ease from the open front.

#### SPECIFICATIONS

##### No. 64 Handy Air-Powered Sofa and Chair Clamp

Standard Max. Capacity		Standard Cylinders			Approx. Wt.
Length	Width	No.	Diam.	Stroke	
86"	38"	4	4½"	2"	2200

##### No. 65 with Air-Powered Slides

No. 65 Air-Powered Sofa and Chair Clamp is of the same construction as the No. 64 except that air-powered front slides, under separate control, enable the operator to remove the sofa and place another one in the clamp with the utmost speed and least effort. Approx. Wt.: 2350.

##### No. 62

##### HAND-OPERATED Sofa Clamp

The construction of this clamp is the same as the No. 64 except that clamping pressure is applied to the two front plates by handwheels which turn heavy quick-acting screws. It will accommodate the same size frames. Approx. Wt.: 2000.

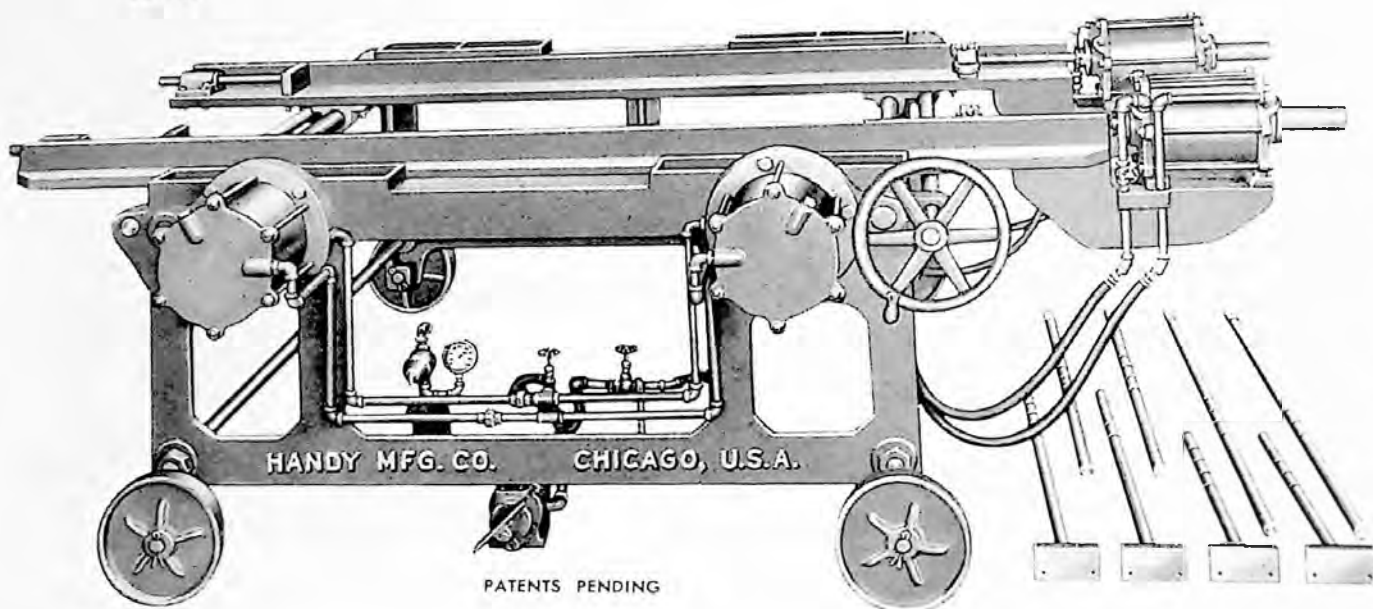
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No. **453**  
SERIES

## SPEED-TRU Sash and Door Clamps



### *Positive Quick-Change from Doors to Sash*

The equally superb efficiency of the No. 453 as either a door clamp or sash clamp makes this unit truly outstanding. Its ability to produce either to perfection is assured by its basic engineering principles. Absolute squaring, speed exceeding that of the fastest operator, and low cost, quality production are all built in to stay.

Through the use of an exclusive Differential-pressure mechanism on each end-pressure unit, sash and doors with stiles either flush or extending beyond the rails are automatically drawn up perfectly.

Setup is faster and simpler than ever. The main clamp-plates are adjusted in a few seconds by turning the handwheel. A pair of the stationary stops are inserted on the left of the clamp-plates and a pair of the pressure rods into the end-pressure cylinders on the right. Perfect alignment is assured by accurately milled slots. This alignment cannot fail; there is nothing to wear and no error possible.

### *FAST, AUTOMATIC TWO-WAY CLAMPING AND SQUARING*

The high efficiency of the No. 453 is due largely to its **EXCLUSIVE CENTER-LINE PRESSURE**. Note that the power of the cylinders is exerted in a **STRAIGHT LINE** directly to the sash or door. This superior principle guarantees truly smooth, precise squaring always.

A single foot-control activates both side and end pressure, and the speed of each is selective. The operator from his station can control the pressure, the speed and the sequence of side and end pressure. He will never use the full pressures and speed which this clamp provides—as with all Handy equipment there is power, ruggedness and speed beyond the demands of any service to which the unit will be put.

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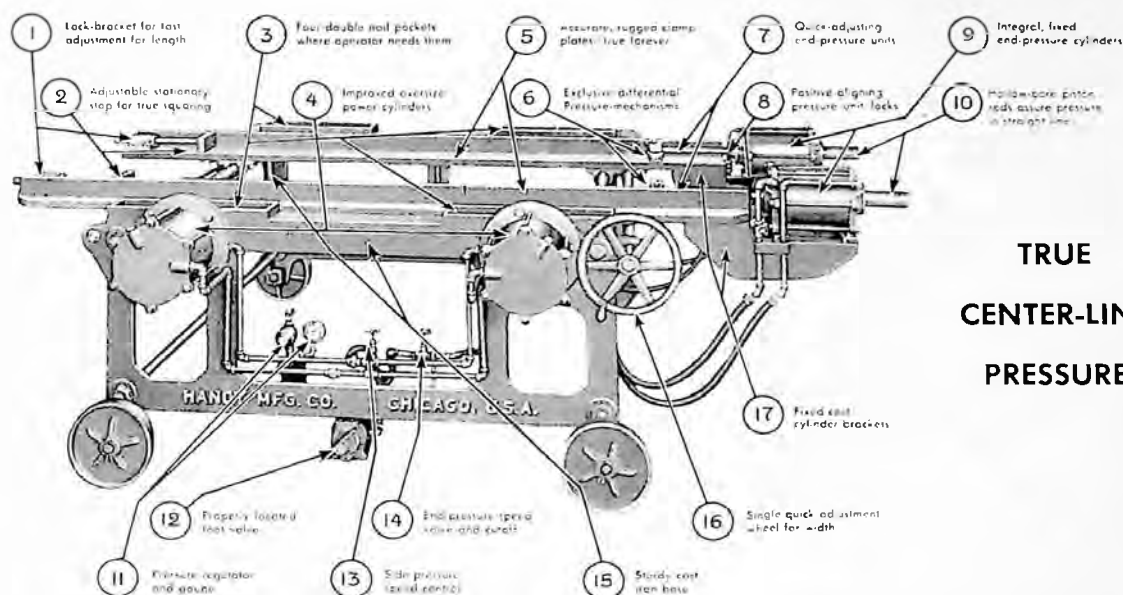
# RUGGED AIR-POWERED DUAL-PURPOSE UNITS



No. **453**  
SERIES

Extra power and correctly applied power — these are the plus values that mean faster production of sash and doors right to dimension every time. Super-adjustability is attained in the Handy No. 453 without sacrifice of absolute accuracy. Thus this unit is the ideal, practical clamp for the small

plant as well as the large one. With these units in operation, production is speeded, setup time reduced to a bare minimum, and the product uniformly improved. The No. 453 is economical to operate due to its superior efficiency and fine engineering.



## DOES TWO JOBS BETTER

Here is a NEW and far better unit . . . it produces either sash or doors, does both more efficiently than ever before. Yet this dual-purpose unit costs less than most old-type equipment which can do but one job!

## Tilted Model Speed-Tru

The Tilted Model Speed-Tru is being used to advantage in certain plants. The doors or sash, instead of being horizontal as in the standard No. 453, are held at about 15° from vertical. This facilitates removal of the sash or door after clamping and frequently permits one man operation on smaller work or smaller production. For the tilted model add the letter "B" to the machine numbers.

## SPECIFICATIONS

No. 453 Series Handy Speed-Tru Air-Powered Sash and Door Clamps

No.	Standard Clamp-Plates			Addl. Max. Stand. Open.	Standard Minimum Clamp Size		Main Cylinders			—End-Pressure Units—			Approx. Wt.
	Lgth.	Hgt.	Open.		Lgth.	Width	No.	Diam.	Stroke	No.	Diam.	Stroke	
453	8'	2"	50"	■	17"	16"	2	8"	5"	2	6½"	5"	2750
454	10'	2"	50"	■	41"	16"	2	10"	5"	2	6½"	5"	3100
455	12'	2"	50"	■	65"	16"	3	10"	5"	2	6½"	5"	3225
456	14'	2"	50"	■	89"	16"	3	10"	5"	2	6½"	5"	3350
457	16'	2"	50"	■	113"	16"	3	10"	5"	2	6½"	5"	3975

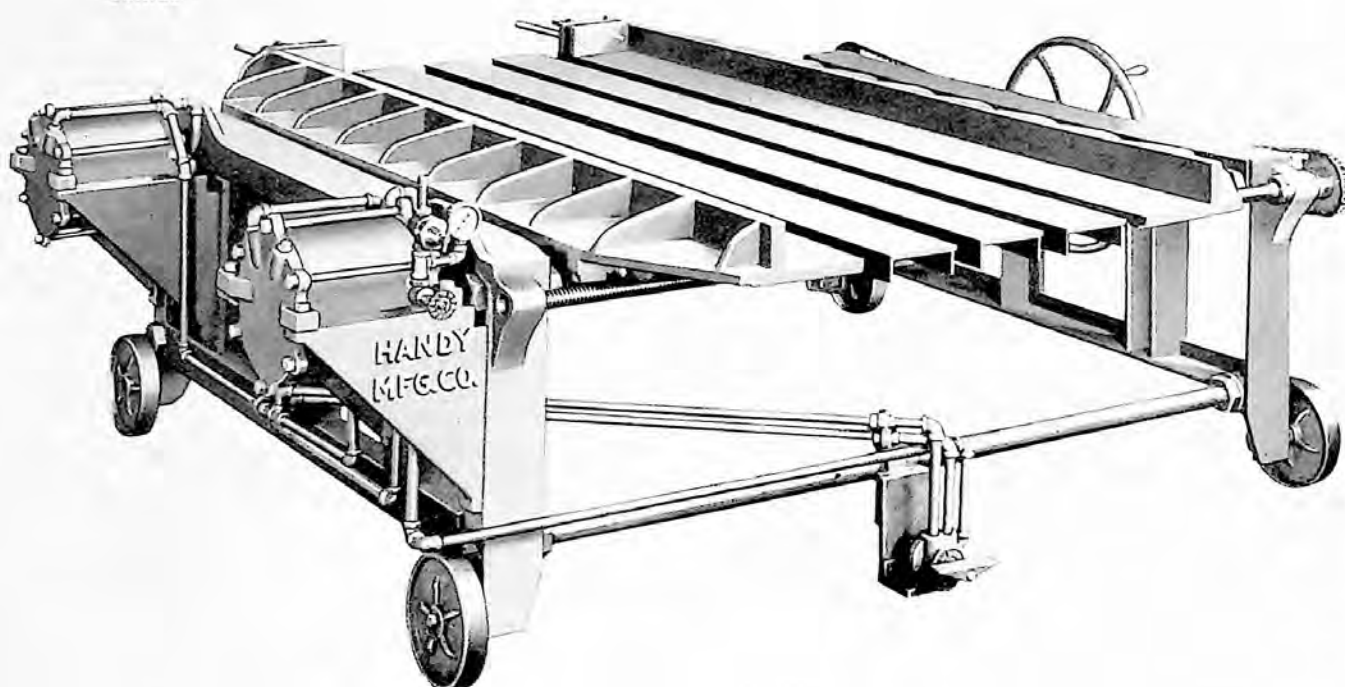
Machines with special dimensions can be supplied to meet any requirements

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No. **424**  
SERIES

## AIR-POWERED Door Clamps



### Heavy Duty Units

This series of clamps is designed especially for clamping heavy and large work such as garage doors, ladders, hanger doors and large section panels. Construction throughout provides extra strength and ruggedness to withstand this heavy duty use.

Adjustment for size is made by turning handwheel and absolute squareness is assured. Adjustable squaring stops, which are easily located, are provided on each clamp-plate. Illustrated on this unit, between

each of the clamp plates, are supports provided to facilitate assembly of the parts in the clamp. These slidable and removable supports are not standard equipment but will be supplied, when specified, at extra cost.

Fast production is assured because of the speed and power of these units. Pressure regulator and gauge and speed control are convenient to the operator. A foot valve is provided so that the operator will have both hands free to guide the work.

End-pressure units, as supplied on the Handy No. 453 Speed-Tru Sash and Door Clamp, if required, can be supplied at additional cost.

### SPECIFICATIONS

No. 424 Series Handy Air-Powered Door Clamps

Standard Clamp-plates					Standard Cylinders			
No.	Length	Height	Stand. Max. Open.	Addl. Max. Open. Add	No.	Diam.	Stroke	Approx. Wt.
424	8'	3½"	42"	■	2	10"	4"	3800
425	10'	3½"	42"	■	2	10"	4"	3950
426	12'	3½"	42"	■	2	10"	4"	4300
427	14'	3½"	42"	▲	3	10"	4"	4800
428	16'	3½"	42"	▲	3	10"	4"	6100
429	18'	3½"	42"	▲	3	10"	4"	7400

Machines with special dimensions can be supplied to meet any requirements.

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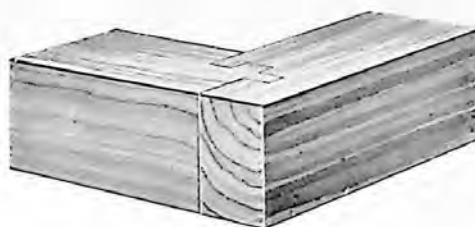


No. **235**  
SERIES

# LOCK-JOINT Chest and Drawer Clamp

For the assembly of cedar chests, drawers and other work employing the type of lock joint illustrated at the right, this unit is a proven producer. For any job made with joints requiring this type of sliding assembly, the lock-joint clamp provides a fast and easy means for assembly and squaring.

Adjustable spring-tension holders are provided to locate sides in the correct position prior to assembly.



## Uniform Pressure

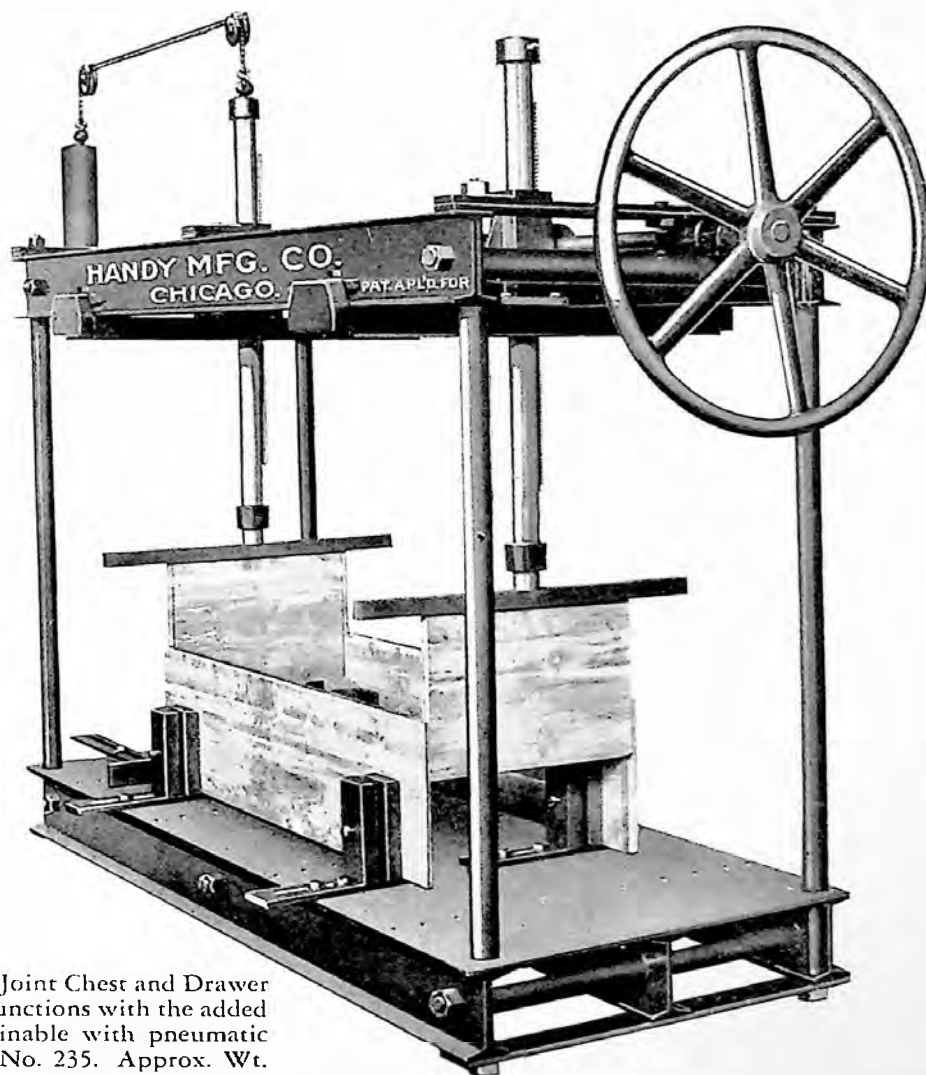
The top pressure members may be positioned for any length of chest, within the capacity of the unit, by sliding them on the shaft. These pressure members have steel racks, engaging with pinions on the shaft, which is operated by the large handwheel. By turning the wheel, uniform pressure is applied simultaneously on each chest end. Weights and pulleys to keep pressure members in top position when loading or unloading are supplied.

### SPECIFICATIONS

#### No. 235 Handy Lock-Joint Chest and Drawer Clamp

Capacity		Approx. Wt.
Length	Width	
26 to 60"	12 to 28"	8 to 18"
		1100

*Machines with special dimensions can be supplied to meet any requirements.*



## AIR-POWERED MODEL

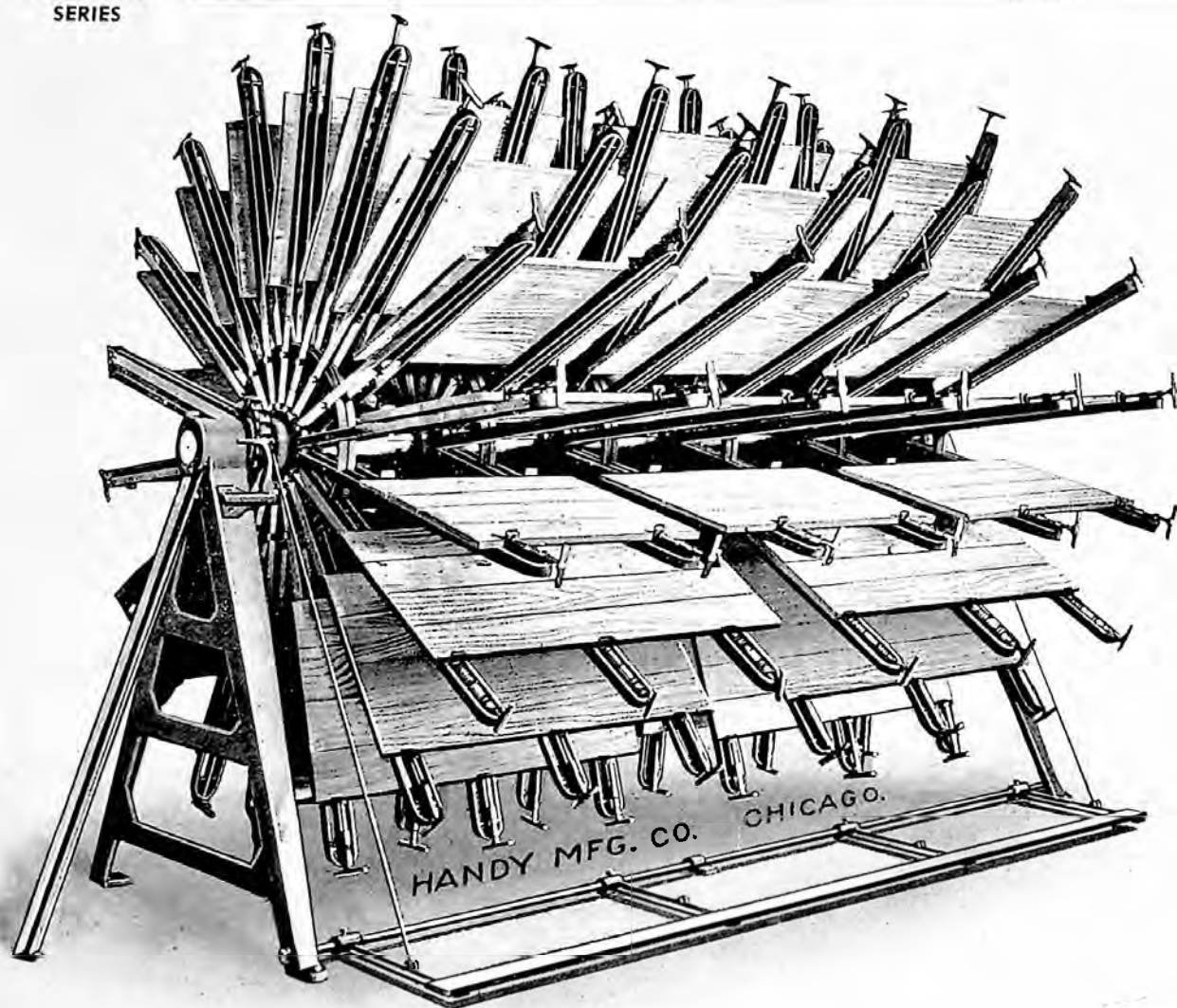
No. 236 Handy Air-Powered Lock-Joint Chest and Drawer Clamp efficiently performs the same functions with the added advantage of ease of operation obtainable with pneumatic equipment. Capacity is the same as No. 235. Approx. Wt. 1450 lbs.

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No. **110**  
SERIES

## REVOLVING Clamp Carriers



Illustrated above is the simplest, most inexpensive and most dependable method ever used for edge-gluing. It is the proven equipment for all but large runs and is especially adapted to the production of many different sizes of cores or plates. Note the various sizes being glued up in the machine shown

above. Bear in mind, too, that it always works, that setup time is virtually nothing, and operating costs, aside from labor, are nil. Many Handy Revolving Clamp Carriers have been in constant service for twenty to thirty years producing today as efficiently as the day they were installed.

*Additional data on next page*



## FOR PRODUCTION EDGE-GLUEING



No. **110**  
SERIES

Ruggedly built Handy Revolving Clamp Carriers have the marked advantage of the greatest simplicity. Moving parts are at a minimum and, production is never interrupted by break-down. Operation is simple, and flexibility to suit any work to be run make these units the ideal basic equipment in smaller plants and a wise adjunct to expensive high production equipment in larger plants.

Each individual clamp consists of three bars providing absolute rigidity. The clamps will not bend and, thus, stock does not buckle. The need for pressure clamps on top is eliminated.

Each clamp carrier consists of a cold rolled steel shaft of any desired length up to 14½ ft. This shaft has a key running its entire length. As many clamp wheels as desired can be placed on this shaft and additional wheels can be added at any time they are required.

Since the movement is entirely rotary the operator, with ease, can bring the next row of clamps into working position simply by stepping on the foot treadle and rotating the carrier in the desired direction. Speeds are equal to or greater than power driven carriers.

## Handy Revolving Carriers in Capacities Up to 825 Square Feet

Each clamp wheel consists of eighteen individual clamps aligned on the shaft by a key-way. Thus, with a minimum of two wheels, eighteen small pieces of work can be edge-glued at a time. By the addition of wheels, the capacity may be increased as desired up to a maximum of eighteen cores each of a maximum size 14½ ft. long or any multiple of small units totalling 14½ ft. by a width of 31" or 38" depending upon the size of carrier clamps.

The back saddle and screw pressure plate, supplied as standard, provide center pressure on stock up to 2" thick. Special saddles and screw plate to provide center pressure on stock up to 4" thick can be supplied. Notches in the center bar of each clamp permit adjustment of the back saddle for any width of stock to be run up to the maximum capacity of the clamp.

### SPECIFICATIONS

Machine No.	No. of Wheels	Max. Capacity Width	Max. Standard Capacity Length	Approx. Wt.
110A	2	31"	5 ft.	2650
111A	3	31"	6 ft.	3000
112A	4	31"	7 ft.	3350
113A	5	31"	8 ft.	3700
114A	6	31"	9 ft.	4050
115A	7	31"	10 ft.	4400
116A	8	31"	11 ft.	4750
117A	9	31"	12 ft.	5100

For 38" clamp capacity change suffix to B.

Additional length of shaft, up to 14½ ft. maximum capacity length, add ■.

Additional wheels of eighteen clamps:

31" Capacity.....118A

38" Capacity.....118B

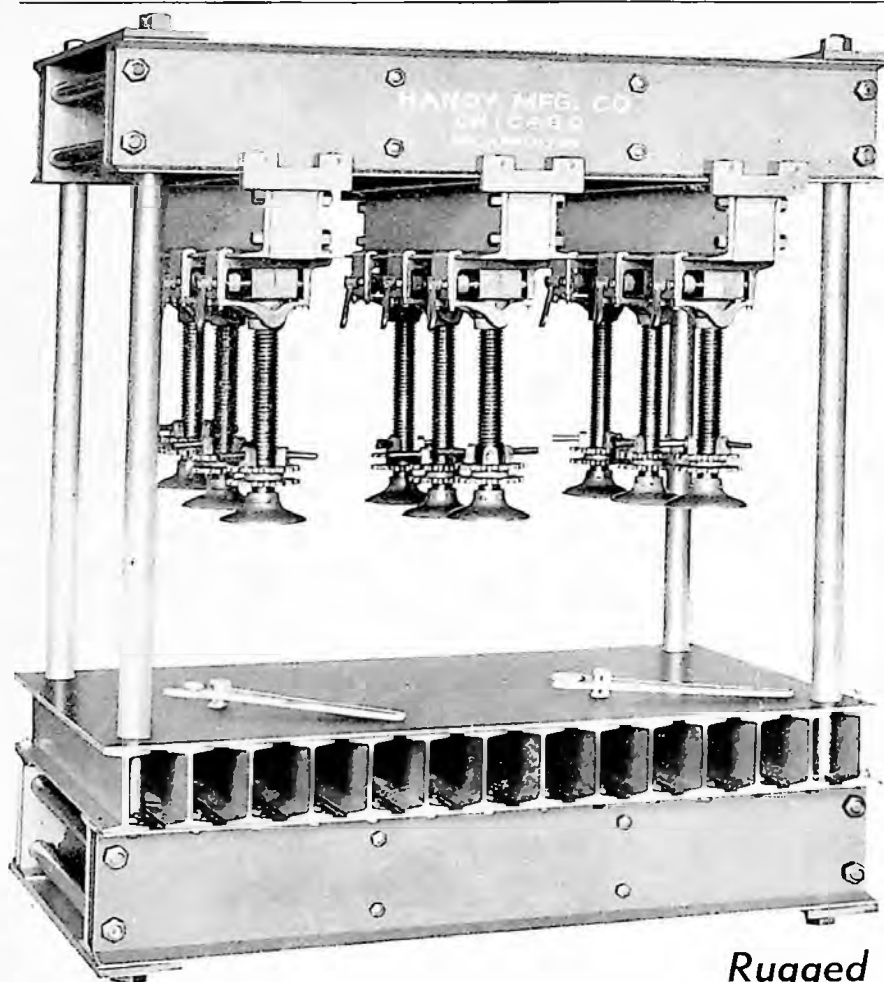
Machines with special dimensions can be supplied to meet any requirements.

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.



No. **345**  
SERIES

## STEEL Veneer Presses



### *Roller-Bearing Crossbeams*

Handy Steel Veneer Presses, the standard of excellence for decades, are built with crossbeams which carry the screw bearings. These crossbeams slide easily on double rollers the full length of the press. Therefore, they can be located to apply pressure wherever required for the particular job being run. Solid type and quick-acting split-type bearings are designed with flanges which slide on crossbeams. This makes possible the correct location of each screw and eliminates complicated mechanisms.

### *Rugged and True*

Every press is built of specially tested steel members and all castings are of a selected malleable alloy. All beams under the bedplate are planed, assuring an absolutely level bed surface. The screws are cut from cold-drawn steel with a full depth standard acme thread. This square thread will withstand the severest pressures. Each screw is equipped with a double sprocket to receive a ratchet-type wrench of special Handy design. Three steel handles on each sprocket are provided to enable the operator to take up slack before applying pressure with the ratchet wrench. Presses are built to withstand pressures in excess of 15,000 lbs. per screw attainable with the standard ratchet wrench.

*Additional data on next page*

## EQUIPPED WITH QUICK ACTING OR SOLID BEARINGS



No. **345**  
SERIES

### *Save Time with Quick-Acting Split Bearings*

BEARING  
CLOSED



Quick-acting split bearings reduce to a minimum the time required to move screws up or down when loading or unloading. The operator merely turns the handle on the bearing to open the split bearing or nut. Then the screw can be pushed up or down. When pushed to the top, a hook is provided to hold the screw in the raised position while loading. When ready to apply pressure the screw is lowered to the work, the handle of the bearing turned and pressure applied with the ratchet wrench. In this way, the Handy quick-acting bearing saves great time by eliminating many turns of the screws of the press. In addition, the operator always has ample headroom when moving work in or out of the press. Counterweights to balance screws, as illustrated on Press No. 340, can be used with any press equipped with quick-acting split bearings but are not regularly supplied.



BEARING  
OPENED

### *Uniform, High Production at Low Cost*

Handy Steel Presses provide an absolutely dependable, low-cost method of obtaining high pressures per square inch. Maintenance and operating costs are little or nothing. A variety of work can be done and size variations up to the maximum capacity of the press are economically and easily handled. There is a size for every type of work and the number of crossbeams and screws can be selected to meet exactly the particular requirements of each plant.

Handy Steel Presses have been depended upon for decades for all types of veneer production. Large loads can be placed in the press and uniformly fine results obtained, due to the fact that the correct

pressure evenly applied may be attained easily. These presses are also widely used for laminating and bonding of plywood, hardboard, Formica, plastics, metals and other materials in the production of table tops, counter tops and displays.

The standard screws have a fast travel of 17" and the standard opening or "daylight" from the press bed to the screws in the raised position is 30". However, to meet any special requirements, this opening can be varied. No matter what the job, Handy can build the press to do the job best.

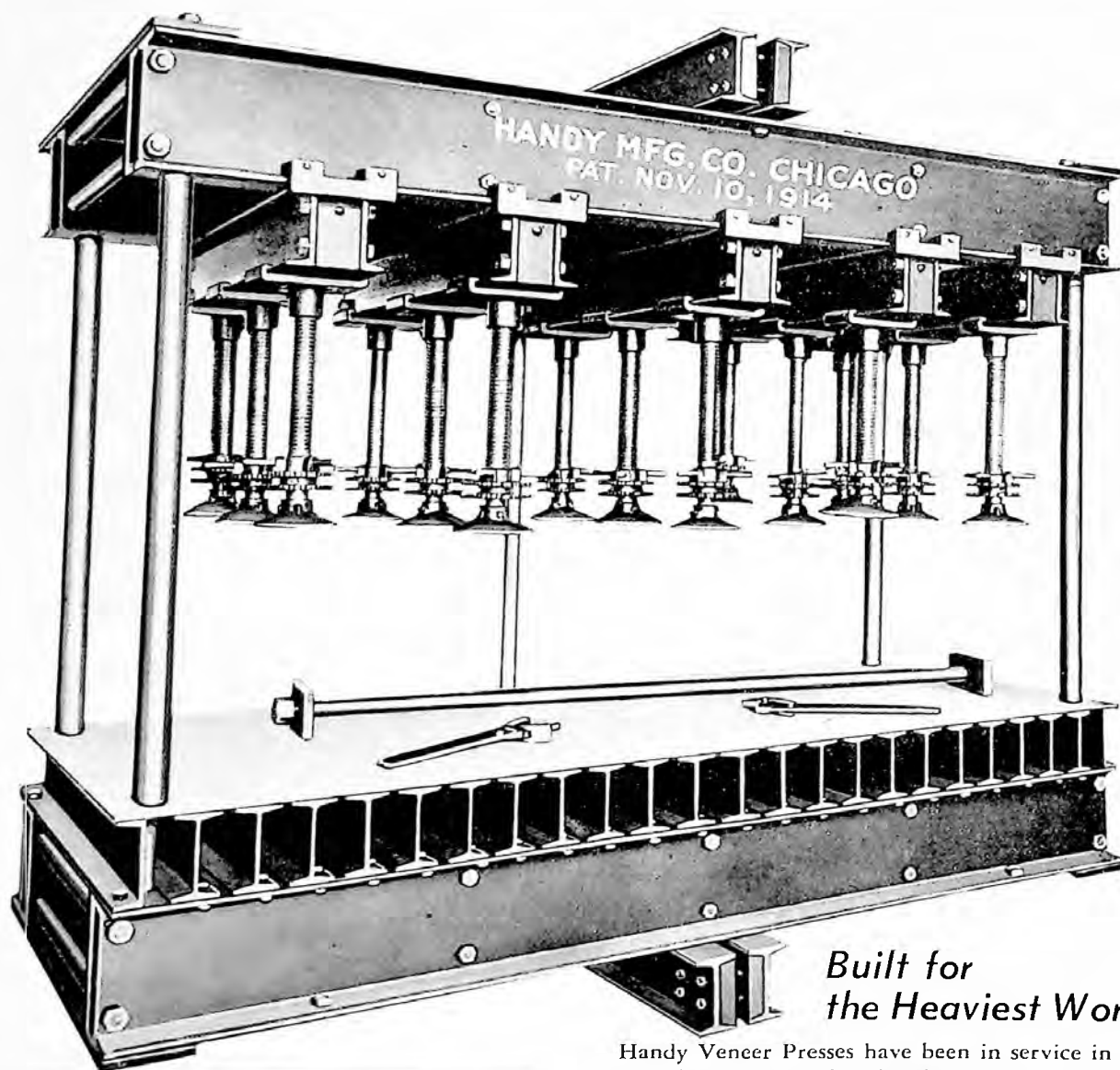
*Additional data on next page*

*HANDY Manufacturing Company*  
CHICAGO 25 U.S.A.



No. **345**  
SERIES

## STEEL Veneer Presses



### Also HYDRAULIC and AIR POWERED PRESSES

For each job and each plant there is a correct, economical press. Frequently, hydraulic or pneumatic presses may, in spite of their greater cost, be the right answer to specific production requirements. Handy stands ready to analyze every production problem and recommend that press, whether screw operated, air-powered or hydraulic, which will produce at the lowest unit cost and provide the desired production capacity. Hot platen presses, also, are a Handy specialty.

### *Built for the Heaviest Work*

Handy Veneer Presses have been in service in all parts of the world for decades — proof of their correct design and reserve strength. All presses eight feet long and longer are supplied with center stress support as illustrated above to prevent any possibility of deflection under heavy loads. When the press is installed, blocks are placed under each end so that the press is supported level above the floor. No expensive installation costs are involved.

# A SIZE AND TYPE BUILT FOR ANY REQUIREMENT



No. **345**  
SERIES

## SPECIFICATIONS — STANDARD SIZES

Press No.	Bed Capacity		No. of Crossbeams	No. of Screws	Approx. Weight
	Length, Feet	Width, Feet			
345	16	8	12	60	22000
346	16	5	10	40	16000
347	16	4	10	30	13600
348	16	3	10	30	13200
348½	14	8	9	45	19000
349	14	5	9	36	13900
350	14	4	9	36	13100
351	14	3	9	27	9800
351½	12	5	8	32	13100
352	12	4	8	32	10300
353	12	3	8	24	7600
353½	10	5	6	24	10300
354	10	4	6	24	8700
355	10	3	6	18	6500
356	10	2	6	12	4400
356½	8	5	5	20	8200
357	8	4	5	20	6600
357½	8	3½	5	15	5150
358	8	3	5	15	4950
359	8	2½	5	10	4400
360	8	2	5	10	3950
361	8	1½	5	5	3350
362	7	3	4	12	4400
363	7	2½	4	8	3850
364	7	2	4	8	3300
365	6	3	4	12	3950
366	6	2½	4	8	3300
367	6	2	4	8	2900
368	5	3	3	9	3300
369	5	2½	3	6	2850
370	5	2	3	6	2450
371	4	3	3	9	2650
372	4	2½	3	6	2200
373	4	2	2	4	1750
374	3	2	2	4	1325
375	2	2	2	4	875
376	1½	1½	2	2	675

Machines with special dimensions can be supplied to meet any requirements. Standard opening or "daylight" from the bedplate to the screws in the raised position is 30". For additional opening add ◊.

Spring-type Roller Loading Tracks facilitate loading especially when Beam Retainers are used. The rollers permit easy positioning of the load and heavy springs support the load so that there is clearance for the beams of the retainers. The tracks are supplied 12" longer than the actual press width.

Any press can be equipped with extra crossbeams or with extra screws and bearings, or both, either with original equipment or as additional later equipment. Prices for additional screws with bearing are shown on the price list.

### Spring-Type Roller Loading Tracks

No.	No.
530 for 1½' wide press	534 for 3½' wide press
531 for 2' wide press	535 for 4' wide press
532 for 2½' wide press	536 for 5' wide press
533 for 3' wide press	539 for 8' wide press

*HANDY Manufacturing Company*  
CHICAGO 25 U. S. A.





No. 830

SERIES

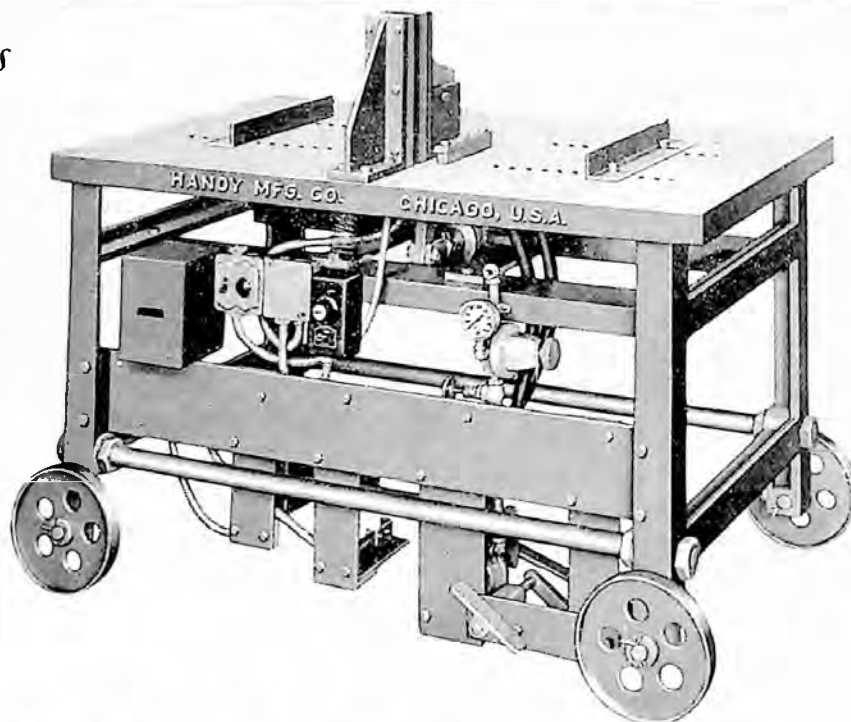
## Joint Sealing Press

### GAUGE TABLE TYPE

A proven method of curing instantaneously the single joint of bent luggage boxes is provided by this Sealer. Whether the joint be scarf, lap, or butt with gusset, this unit holds the box to dimension and, through the use of heat and pressure, seals the joint usually in less than one minute. Unit is electrically heated, thermostatically controlled and electrically timed.

#### No. 830 Handy Sealing Press

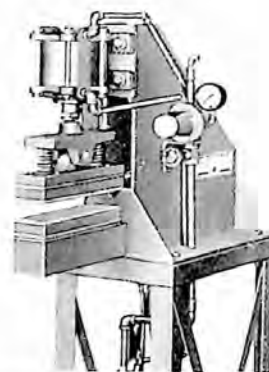
Length	Width	Height
8" to 48"	8" to 21½"	11"
Cylinder: Diam. 6½", Stroke 1"		
Approx. Wt.: 1200 lbs.		
Platens: 4" x 11", Open. 1"		
Both 230 and 115 V., 60 Cy.		



## Joint Bonding Press

### HORN TYPE

The No. 833 Bonding or Sealing Press is used for the same purpose as the No. 830 press but is of the horn type and does not provide a work table nor the gauges for sizing the boxes. The electrically heated, thermostatically controlled platens are 3" wide by 11" long so that the ideal heat to cure the thermo-setting resin glue is maintained at all times automatically. Likewise, an automatic electric timer is provided so that the press will open at the end of the time interval. Thus, uniformly good joints are guaranteed, and hourly production governed by timing the cycle automatically. These presses are the best equipment for making use of modern technology for fast glue bonding.



#### No. 833 Handy Bonding or Sealing Press Horn Type

Platen Size: 3" x 11"
Standard Current: Both 230 and 115 Volt
Maximum Opening: 1½"
Cylinder: Diameter 4½", Stroke 1½"
Approx. Wt. 400 lbs.

Machines with special dimensions can be supplied to meet requirements.

*HANDY Manufacturing Company*

CHICAGO 25 U.S.A.

# AIR-POWERED THERMOSTATICALLY-CONTROLLED ELECTRICALLY-TIMED SPEED PRESSES



**No. 835  
SERIES  
No. 850**

Patents Pending

## *No. 835 Bonds Top and Bottoms to Luggage Boxes and Cases in 1 to 2 Minutes Ready for Machining*

Plants using modern methods are rapidly installing heated-platen presses for bonding boxes and case tops. Through the use of these presses with thermo-setting glues, it is possible to produce in one to two minutes a strong glue joint and the boxes are ready for subsequent machining operations almost immediately. The platens are electrically heated and thermostatically controlled. The press cycle is timed automatically.

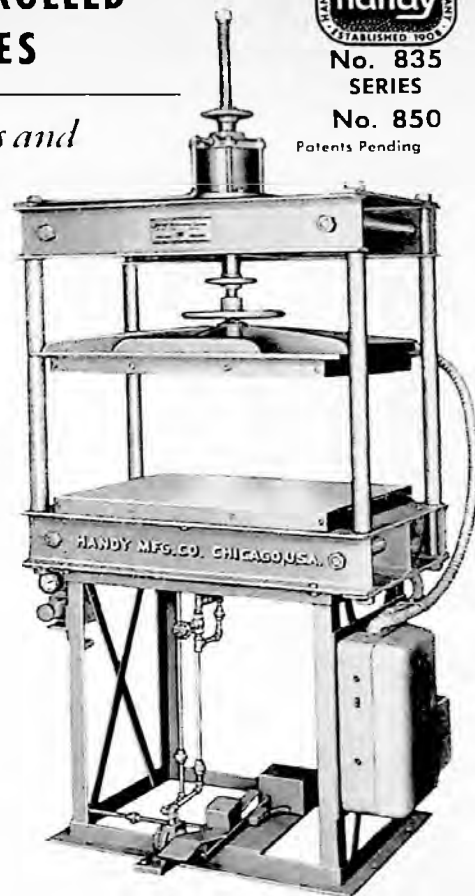
Through the use of the exclusive Handy hollowbore cylinder, an extremely wide range can be accommodated without excessive stroke. This conserves air and time. The platen is adjusted to the desired opening by the handwheels at the top of the press.

### SPECIFICATIONS

#### **No. 835 Handy Adjusto Air-Powered Case and Box Sealing Press**

Platens: 22" x 32"	Standard Current
Standard Maximum Opening: 14½"	Both 230 Volt and 115
Standard Minimum Opening: 4½"	Volt, 60 cycle
Cylinder: Diameter 6½", Stroke 2"	Approx. Wt.: 1600 lbs.

*Presses with special dimensions can be supplied to meet any requirements.*



## *No. 850 Bench Press*

This air-powered bench press is used for a wide variety of assembly and fabricating operations. It is ruggedly built and the platens are arranged so that special forms, tools or fixtures may be attached. Operation is fast and the control valve has a spring return so that the press opens automatically when the operator takes pressure off the foot pedal. Complete with speed valve, pressure regulator and gauge.



### SPECIFICATIONS

#### **No. 850 Handy Air Powered Bench Press**

Upper Platen: 4" x 8"
Lower Platen: 8" x 12"
Cylinder: Diameter 6½", Stroke 2½"
Total Pressure: 33 Times Line Pressure
Approx. Wt.: 150 lbs.
Maximum Standard Opening: 10"
Throat from Piston Center Line: 6"
Max. Pressure, 125 lb. line: 4000 lbs.
<b>No. 850A Stand for No. 850 Press</b>

*Presses with special dimensions can be supplied to meet any requirements*

### SPECIFICATIONS

#### **No. 836 Handy Case and Box Sealing Press**

Platens: 22" x 32"
Standard Maximum Opening: 9½"
Standard Minimum Opening: 5½"
Cylinder: Diameter 6½", Stroke 4"
Standard Current
230 Volt
115 Volt, 1 Phase, 60 Cycle (for timer)

Approx. Wt.: 1560 lbs.

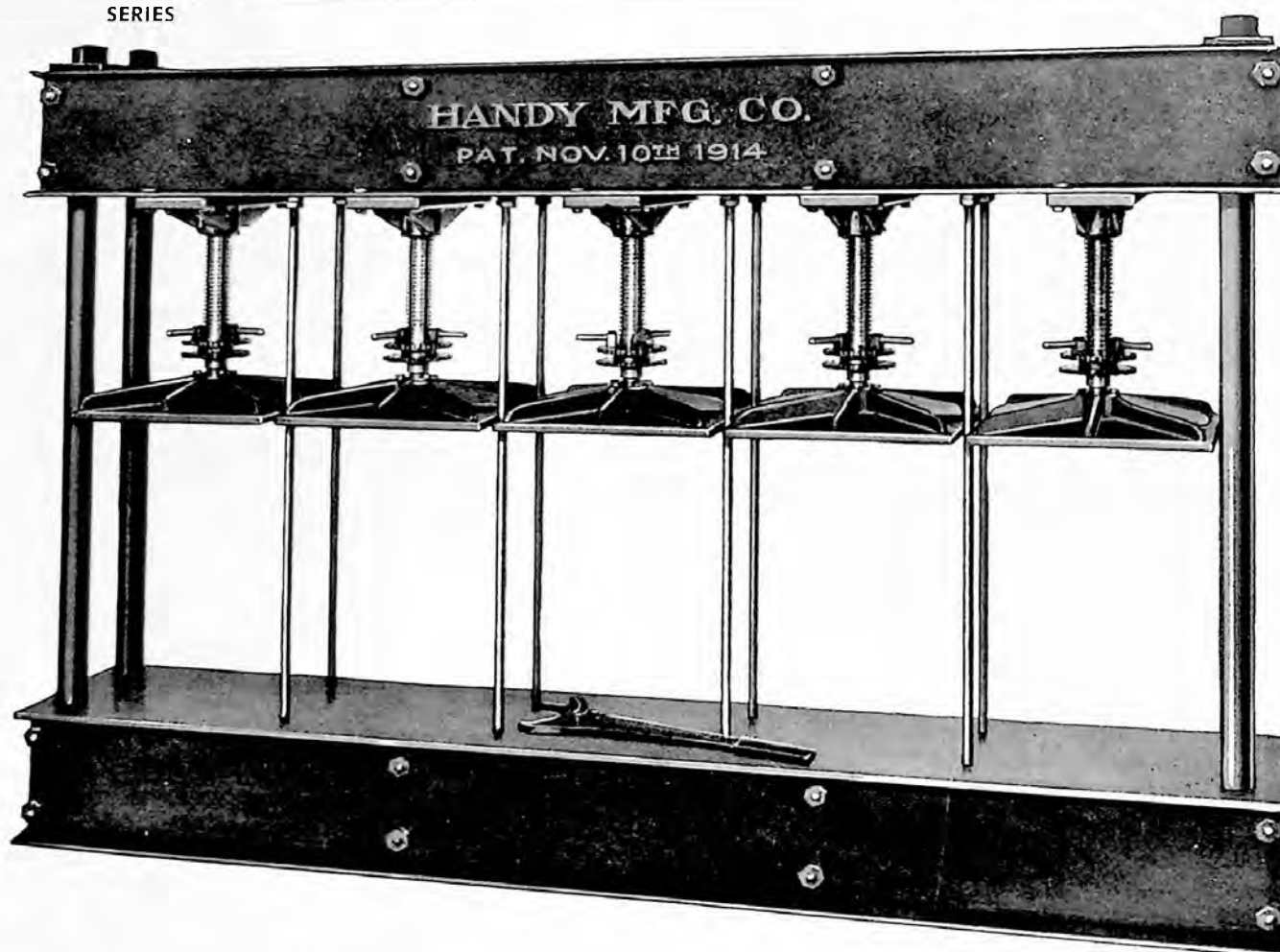
*Presses with special dimensions can be supplied to meet any requirements.*

**HANDY** Manufacturing Company  
CHICAGO 25 U.S.A.



No. **377**  
SERIES

## STEEL Stacking Presses



### Wide Range of Sizes

Handy Stacking Presses are adaptable to a variety of production jobs. They are built in a wide range of sizes and standard units are supplied with spaces 16" wide and are equipped with pressure plates 16" x 16". Heavy cut thread screws are 2" in diameter with quick Acme thread.

Movement to and from the work is speeded by the use of the three steel handles on each screw. Final tightening to obtain the desired pressure is done with the special ratchet wrench supplied. The press illustrated in No. 378.

### SPECIFICATIONS

Press No.	No. of 16" x 16" Spaces	Approx. Wt.
377	3	1450
378	5	2450
379	8	3950
380	10	5000
381	15	7500

Standard opening or "Daylight" from the bedplate to the screws in the raised position is 30". For additional opening add ▲. Standard travel of screws is 17".

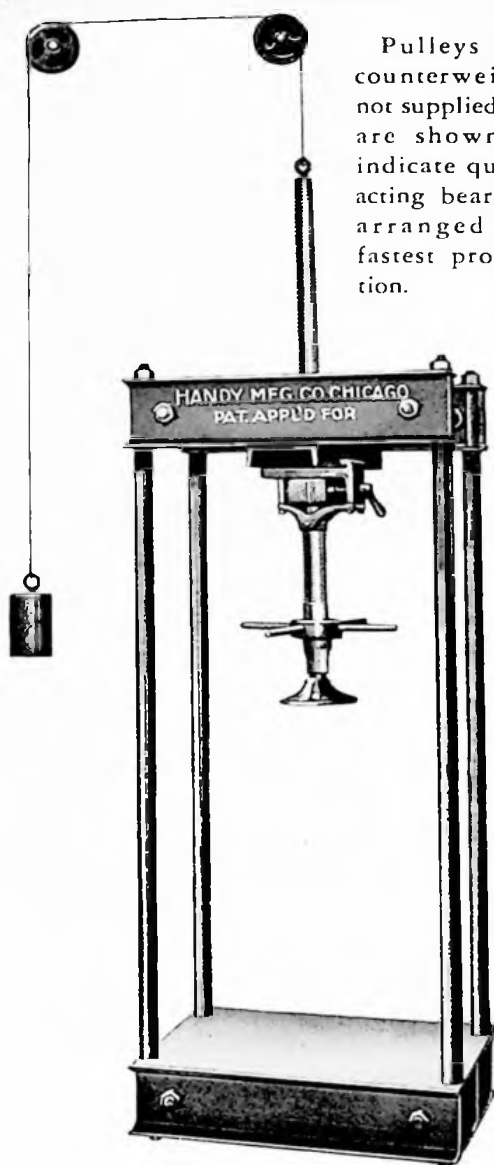
Machines with special dimensions can be supplied to meet any requirements.

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CHICAGO 25 U. S. A.



No. **340**

## Quick-Acting Press



Pulleys and counterweight not supplied but are shown to indicate quick-acting bearings arranged for fastest production.

This press, 24" x 20" in the clear, is equipped with Handy quick-acting bearing and long screw having 30" travel. The opening from bedplate to screw is 36". For additional opening add ■. Presses for any desired capacity can be supplied on special quotation.

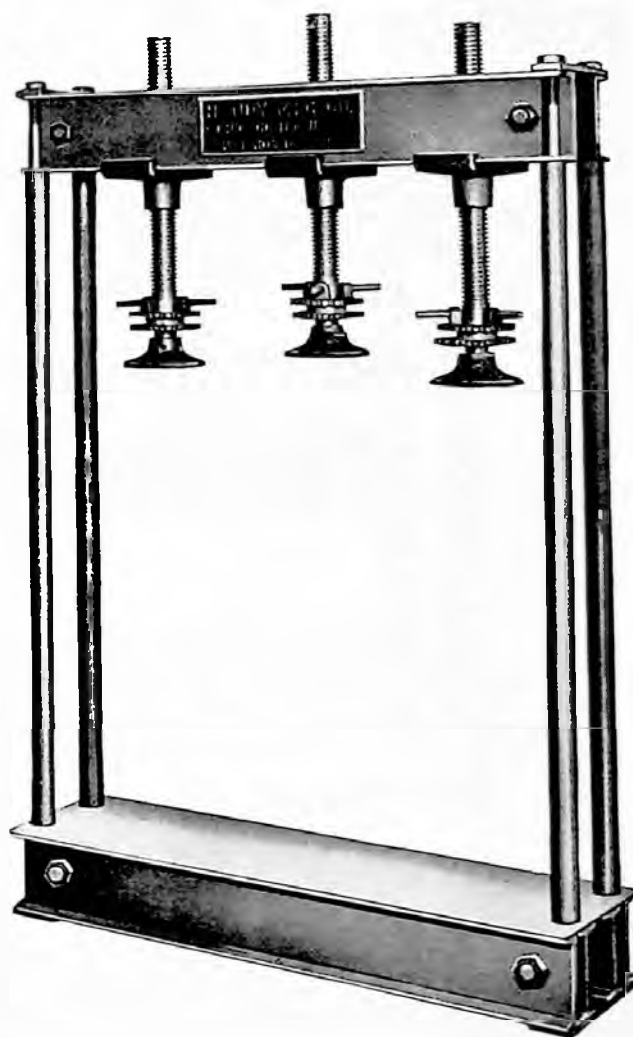
This press is for variety of work such as gluing on tops and bottoms of boxes and cases.

**No. 340**—Handy Quick-Acting Steel Press. Approx. weight 425 lbs.



No. **330**

## Sectional Press



Sectional Steel Presses are frequently used in multiples where work sizes vary greatly. The standard press shown is 40" long by 11" wide in the clear. It is equipped with three two-inch screws with solid bearings, adjustable in position. Screw travel is 17". Standard opening from the bedplate to the screws in a raised position is 30". Additional opening add ■. Sectional Presses of any desired capacity and any number of screws can be supplied.

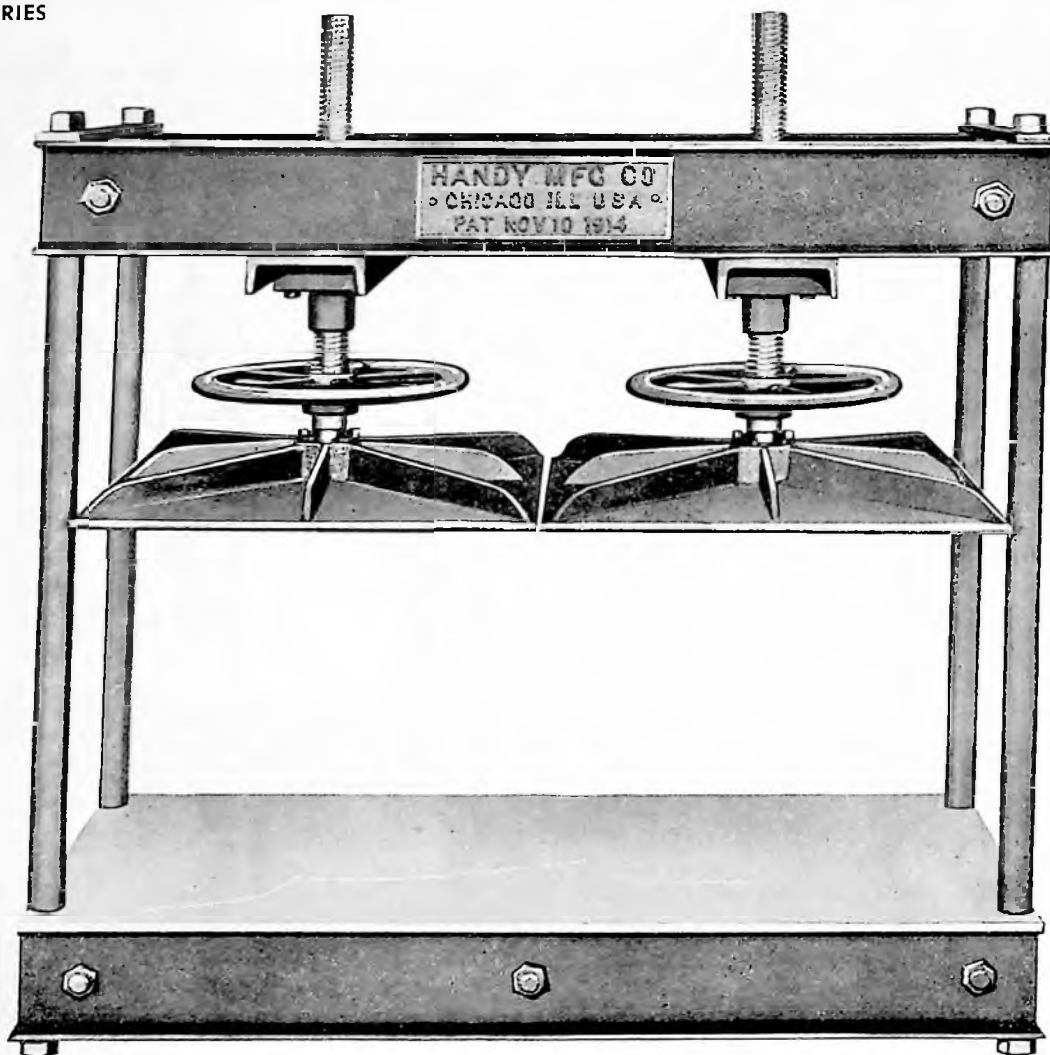
**No. 330**—Press with solid bearings. Approx. weight 475 lbs. For additional cost of quick-acting split bearings, see price list.

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No. **320**  
SERIES

## PRESSURE PLATE Steel Presses



The standard No. 320 Press, illustrated above, has a capacity in the clear 4' x 2'. Each two-inch screw with solid bearing is operated by a handwheel sixteen inches in diameter. Pressure plates are 24" x 24" and have a travel of 17".

The No. 310 Steel Press has the same capacity as No. 320 but, instead of 24" square pressure plates, each screw is equipped with flange 6½" in diameter. This press is extensively used for such work as clamping cabinet tops.

### SPECIFICATIONS

Press No.	Length	Width	Approx. Wt.
320	4 ft.	2 ft.	950
310	4 ft.	2 ft.	650

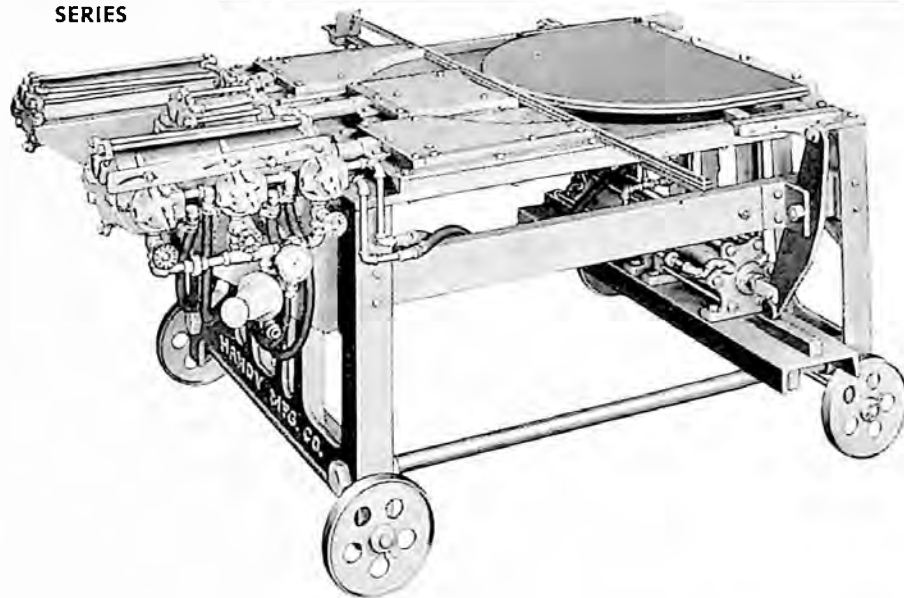
Standard opening or "Daylight" from bedplate to screws in the raised position is 30". For additional opening add ■. Presses with other capacities, more or less screws, or with pressure plates in special sizes, can be built to meet any requirements.





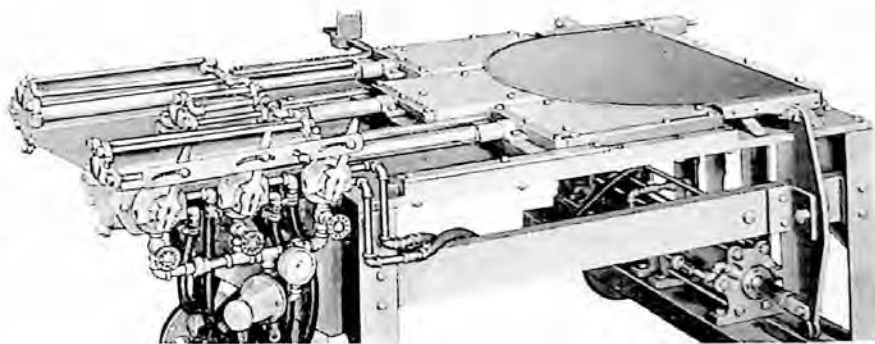
No. **601**  
SERIES

## AIR-POWERED Table Molding Inserter



For the application of extruded aluminum moldings to half-round or half-oval table tops, this machine has eliminated most of the hand work previously required. It avoids defacing of the molding and has the ability to maintain a high rate of daily production so frequently required by the manufacturer of dinette and restaurant tables. Simply by changing the wooden pressure blocks, a large range of sizes can be accommodated in a single machine providing the flexibility that is essential in modern plants. This machine will also insert moldings on short filler leaves as well.

*Table Top  
Trim Moulding  
Inserted with  
Minimum Effort  
and Great Speed*



After the table top is set on the machine, the trim cut to proper length is set against the locating stop. The operator throws the first valve activating the center cylinder which, in turn, forces the form against the trim and the trim around the top. The operator then throws the second valve which activates the outer two cylinders for forming and driving the molding. The third valve is then operated which actuates the cylinders located beneath the table top which completes the forming and inserting operation. A single motion of the valve tie-lever releases the pressure of all cylinders simultaneously ready for a repetition of the assembly cycle. Pressure blocks are not supplied but are easily made to suit the curvature of the top and shape of the molding.

### SPECIFICATIONS

#### No. 601 Handy Air-Powered Table Molding Inserter

Maximum Size of Top		Minimum Size of Top		Cylinders		Approx.
Width	Length	Width	Length	No.	Diam.	Wt.
34"	24"	30"	12"	5	8"	1500

*Machines with special dimensions can be supplied to meet any requirements.*

### Inserters for All Shapes of Tops

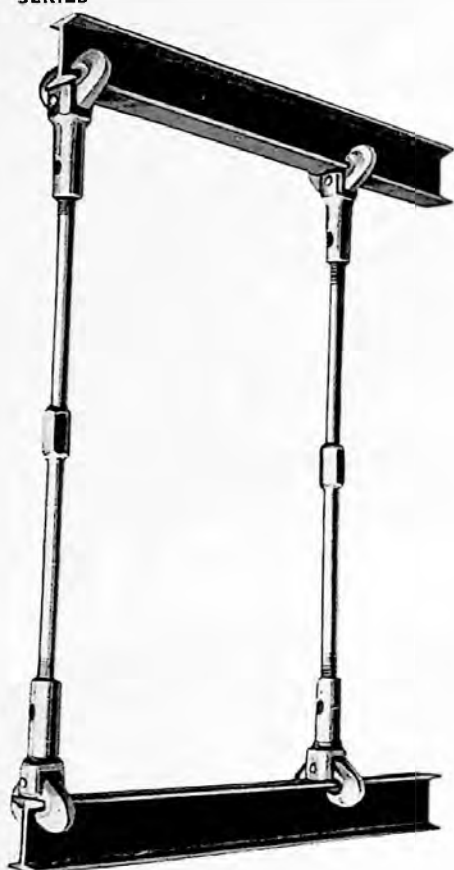
Special machines are available for square, rectangular, and a combination of these with half-round or oval tops. Special machines can be designed for your special requirements.

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CHICAGO 25 U. S. A.



No. **501**  
SERIES

## Retainer Clamps



To increase the production of screw or hydraulic presses, these retainers are placed in the press and, after pressure has been applied, the retainers are drawn up so that the entire load may be removed under pressure until the glue sets. The press is thus made available at once for another load.

The special feature of these retainers is the flexible joint at each end of the rods which prevents undue strain. Each beam is 4" high. Illustrated is one set with beams.

No.	Width Capacity (horizontal)	No.	Width Capacity (horizontal)
501	18"	504	36"
502	24"	505	42"
503	30"	506	48"

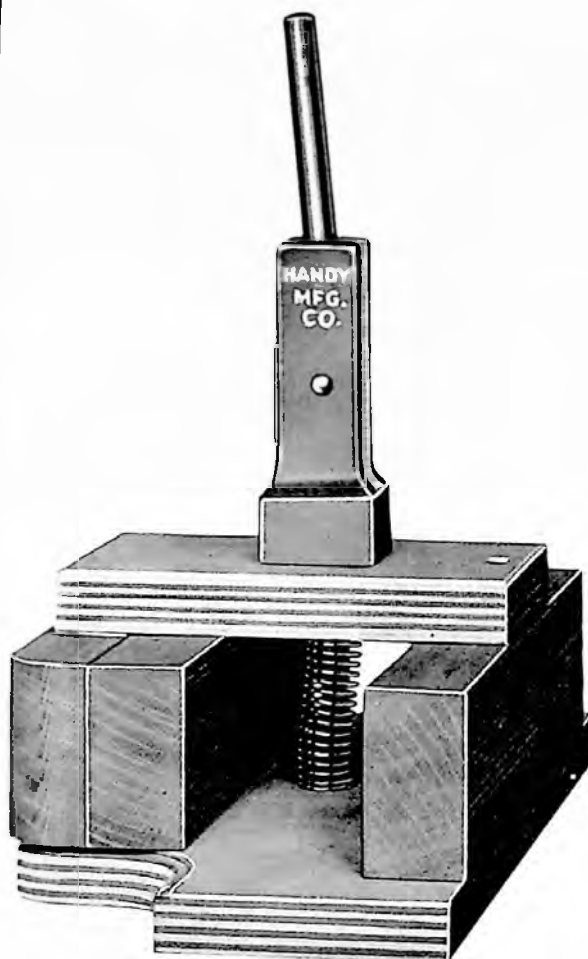
No. 507—Rods only (no beams).

Standard maximum opening between beams (measurement between beams) 24". Additional opening add ★.



No. **510**

## Shaper Clamp



The No. 510 Shaper Clamp is designed to meet the demand for a more rugged and reliable clamp. It is so built that it cannot jar loose since the eccentric mechanism is at dead center when pressure is fully applied and does not depend on friction to maintain pressure. Hundreds of plants have found by experience that this is the best shaper form clamp. Illustrated above is the Handy Shaper Clamp attached to a form and the stock to be machined is clamped.

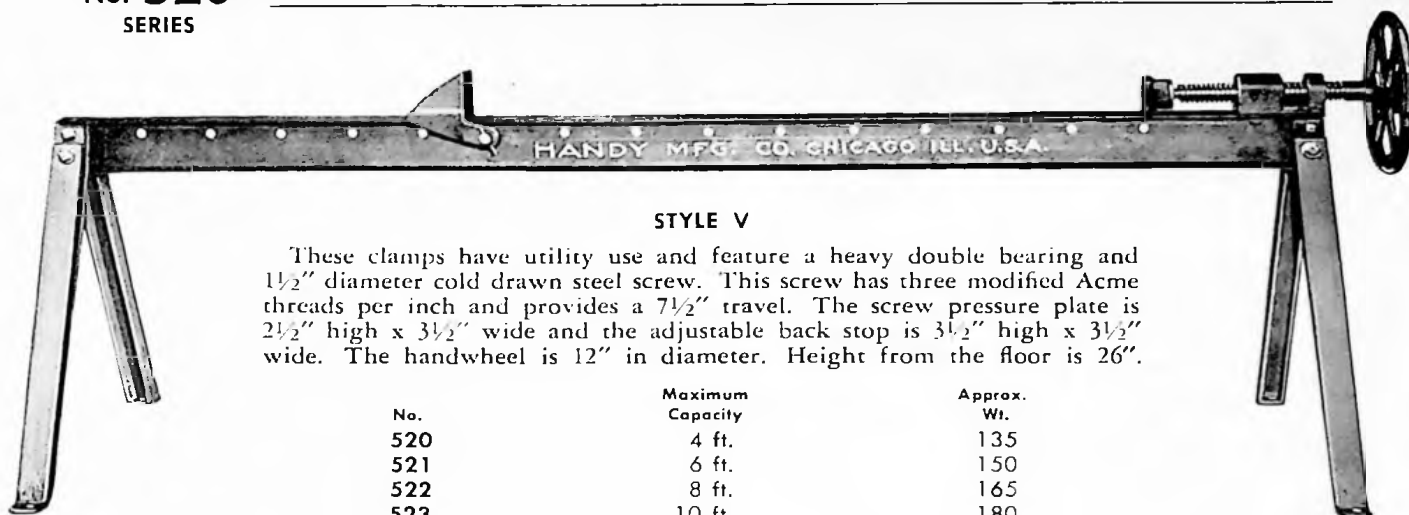
No. 510—Handy Shaper Clamp.

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No. **520**  
SERIES

## STEEL BEAM Trestle Clamps



STYLE V

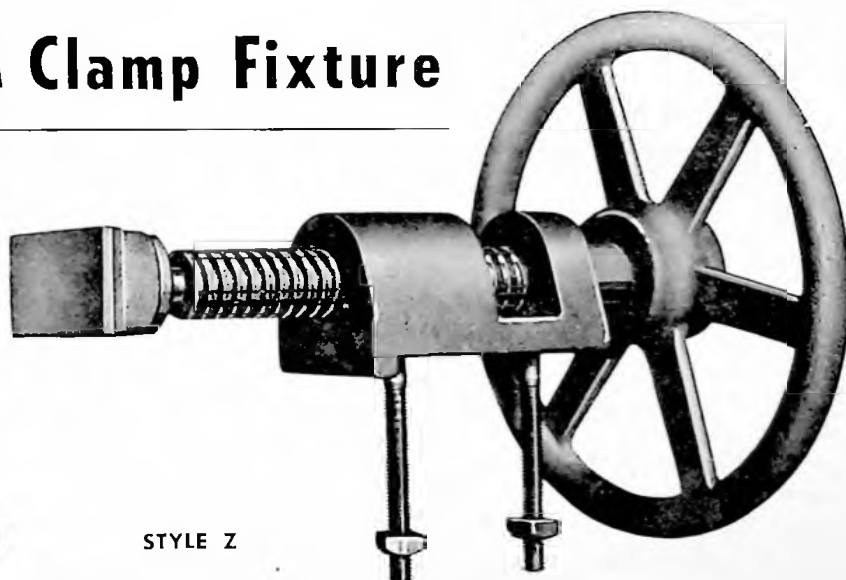
These clamps have utility use and feature a heavy double bearing and  $1\frac{1}{2}$ " diameter cold drawn steel screw. This screw has three modified Acme threads per inch and provides a  $7\frac{1}{2}$ " travel. The screw pressure plate is  $2\frac{1}{2}$ " high x  $3\frac{1}{2}$ " wide and the adjustable back stop is  $3\frac{1}{2}$ " high x  $3\frac{1}{2}$ " wide. The handwheel is 12" in diameter. Height from the floor is 26".

No.	Maximum Capacity	Approx. Wt.
520	4 ft.	135
521	6 ft.	150
522	8 ft.	165
523	10 ft.	180
524	12 ft.	195



No. **515**

## WOOD BEAM Clamp Fixture



STYLE Z

The Handy Wood Beam Clamp Fixture is built of steel and iron for heavy duty use. It will fit any size wood beam up to  $3\frac{1}{2}$ " x  $4\frac{1}{2}$ ". The  $1\frac{1}{2}$ " cold drawn steel screw with three modified Acme threads per inch has a travel of 6". The double screw bearing assures smooth operation and longer life. The handwheel is 12" in diameter. The screw pressure plate is  $2\frac{1}{2}$ " high and  $3\frac{1}{2}$ " wide and the backstop is  $3\frac{7}{8}$ " high x  $3\frac{1}{2}$ " wide.

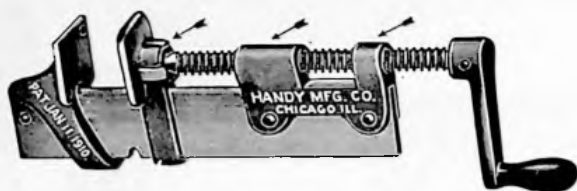
No. 515—Handy Wood Beam Clamp Fixture, complete as illustrated. Approx. weight 40 lbs.

No. 516—Same, but without backstop. Approx. weight 32 lbs.

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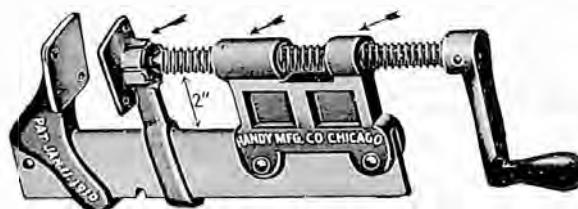


# TEMPERED Steel Bar Clamps



STYLE C

For clamping stock up to 2" thick



STYLE F

For clamping stock up to 4" thick

No.	Capacity	No.	Capacity
BC-1	1 ft.	BC-7	7 ft.
BC-1 1/2	1 1/2 ft.	BC-8	8 ft.
BC-2	2 ft.	BC-9	9 ft.
BC-2 1/2	2 1/2 ft.	BC-10	10 ft.
BC-3	3 ft.	BC-11	11 ft.
BC-3 1/2	3 1/2 ft.	BC-12	12 ft.
BC-4	4 ft.	BC-13	13 ft.
BC-5	5 ft.	BC-14	14 ft.
BC-6	6 ft.	BC-15	15 ft.

No.	Capacity	No.	Capacity
BF-1	1 ft.	BF-5	5 ft.
BF-1 1/2	1 1/2 ft.	BF-6	6 ft.
BF-2	2 ft.	BF-7	7 ft.
BF-2 1/2	2 1/2 ft.	BF-8	8 ft.
BF-3	3 ft.	BF-9	9 ft.
BF-4	4 ft.	BF-10	10 ft.



Handle No. 2

Unless otherwise specified, all Style C and all Style F Clamps are supplied with Handle No. 1 which is illustrated on the clamps above. However, Handles No. 2 or No. 3, if specified, can be supplied without extra charge.



Handle No. 3

## Exclusive Long-Life Double Bearing

Superiority of Handy Steel Bar Clamps is universally recognized. Notice the double bearing construction which provides two bearings for the screw. This greatly increases the usable life of each Handy Bar Clamp.

Special alloy malleable castings are used throughout. The bars, which are 1 1/2" x 5/16", are made of specially developed tempered spring steel and will not bend in normal service under heavy loads. The saddle, made in one piece, is placed in the desired notch on the steel bar to adjust for size.

Long, trouble-free service is assured because Handy Bar Clamps have no catches or small parts to get out of order. Handles are one-piece construction. The modified Acme fast action screws are five-eighths inch cold drawn steel and have a travel of 3 1/2".

Furniture and woodworking plants all over the world have been depending upon Handy Bar Clamps for over forty years. They are so made that the stock does not buckle when clamping pressure is applied and they may be counted upon to give service far beyond expectations.

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CHICAGO 25 U. S. A.

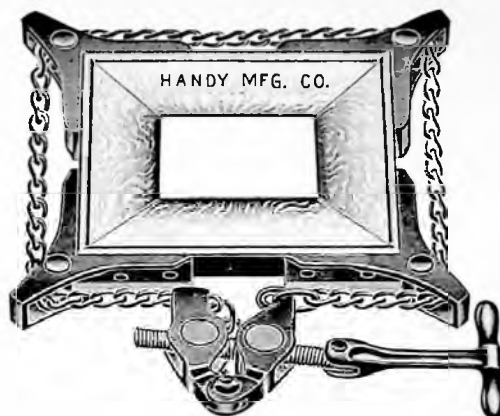


# CHAIN Frame Clamp

## STYLE N

These clamps are widely used for clamping frames, boxes or other small work with mitre joints which must be kept under pressure until the glue is set. The low cost of these clamps warrants the use of a sufficient number to accomplish that purpose.

The tightening device has a right and left hand thread and



## STYLE N

assures uniform pressure at all four corners. Standard corners are  $1\frac{1}{8}$ " high.

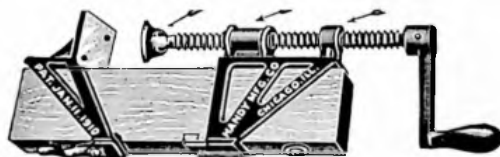
When ordering, add one additional foot of chain to actual length required. Clamp may be used for any work smaller than its maximum capacity down to a minimum size of 6" x 6".

No.	Length of Chain	No.	Length of Chain	No.	Length of Chain
N-4	4 ft.	N-12	12 ft.	N-17	17 ft.
N-6	6 ft.	N-13	13 ft.	N-18	18 ft.
N-8	8 ft.	N-14	14 ft.	N-20	20 ft.
N-10	10 ft.	N-15	15 ft.	N-22	22 ft.
N-11	11 ft.	N-16	16 ft.	N-24	24 ft.

Style N Chain Frame Clamps can be supplied with corners  $2\frac{1}{4}$ " high instead of the standard  $1\frac{1}{8}$ " high. When ordering, add letter "H" to the above numbers and to the price add  $\diamond$ .



## STYLE D CLAMP FIXTURE



This fixture is designed to be attached to a wood bar  $2\frac{1}{2}$ " x  $1\frac{1}{4}$ ". Lugs are provided in the fixture to fit into notches on the wood bar and a bolt goes through the wood. A cold drawn, machine cut screw operating in a double bearing assures superlative results. Castings are malleable. No. D1



## STYLE G CARRIAGE CLAMP



Handy Style G Carriage Clamps are made of malleable iron, heavily ribbed to provide great strength and prevent twisting. The screw is  $\frac{3}{8}$ " in diameter and is cut from cold drawn steel. Pressure button on end of screw will not come off.

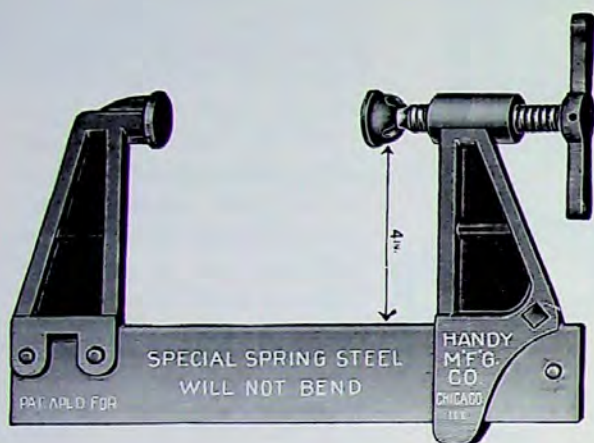
No. 508 6" Capacity No. 509 8" Capacity

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## HIGH JAW Bar Clamp



STYLE S

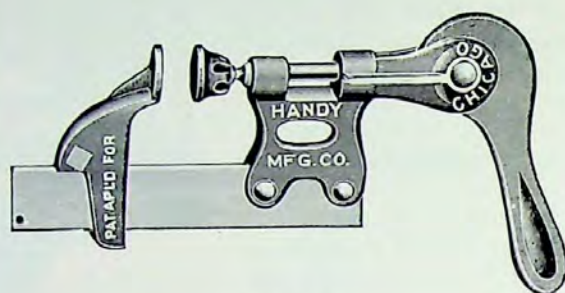
Style S Bar Clamps are especially useful for gluing thick or wide stock as well as for clamping forms or stops on machines. Quick adjustment of the screw bearing on the bar is provided by the hardened steel key. It will not slip.

Center pressure is exerted 4" above the bar by a  $\frac{5}{8}$ " cold drawn steel screw. The pressure button will not come off. The heavy tempered spring steel bar is 2" x  $\frac{3}{8}$ ". Castings are finest malleable.

No.	Capacity	No.	Capacity
S-44	4 in.	S-2	2 ft.
S-66	6 in.	S-2½	2½ ft.
S-88	8 in.	S-3	3 ft.
S-100	10 in.	S-4	4 ft.
S-1	1 ft.	S-5	5 ft.
S-1½	1½ ft.	S-6	6 ft.



## STEEL Eccentric Clamp



STYLE X

In long use, the Handy Eccentric Clamp has demonstrated its ability to do better work longer. The plunger operates in a double bearing and the eccentric member is made with two flanges, providing a double bearing for the shaft. The saddle with hardened tool steel key is quick-adjusting and will not slip when placed at any desired position on the bar even when work is hammered after applying pressure. Castings are malleable iron. The bar is tempered spring steel 1½" x  $\frac{5}{16}$ " and other parts are cold drawn steel.

No.	Capacity	No.	Capacity
X-1	1 ft.	X-4	4 ft.
X-1½	1½ ft.	X-5	5 ft.
X-2	2 ft.	X-6	6 ft.
X-2½	2½ ft.	X-7	7 ft.
X-3	3 ft.	X-8	8 ft.

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B E N D I N G

# PRESSES



*T*HROUGHOUT the world, Handy Round Corner Hot Roll Bending Presses have become famous. These presses provide an entirely different, thoroughly proven method of production bending, usually without prior machining or preparation of any kind. Stock plywood panels and hardboard, such as Masonite Presdwood, are fabricated on Handy Bending Presses with equal facility even by unskilled operators.

These presses are now used routinely for the production of furniture, radio and television cabinets, luggage, trailercoaches and many other products where the advantages obtained by the elimination of joints, simpler design, faster production, and greater strength are wanted.

Bending of stock of various thicknesses, to various radii and to the desire amount of bent, 90° or more or less, are usually made in less than two minutes. Designs requiring several bends in each piece are easily produced.

Handy makes, in addition, a wide variety of presses for forming plywood and hardboard to exact contours and for molding veneers into plywood of irregular contour. These modern presses permit the production of better, more functional products at lower cost.



Bulletin No. 800 describes in detail Handy Bending Presses, Hot Die Molding Presses, Chair Seat and Back Presses and special purpose presses. Ask for this bulletin, and submit details of the job you wish to do. You will get complete recommendations by Handy. Depend upon Handy to provide the equipment to accomplish best your special production problems.

HANDY MANUFACTURING COMPANY    2432 West Lawrence Avenue    CHICAGO 25 U. S. A.



CATALOG No. 37

CLAMPING MACHINERY

PRESSES

ASSEMBLY MACHINERY

WOODWORKERS' CLAMPS